

Grizzly *Industrial, Inc.*®

MODEL G0561 7" x 12" METAL-CUTTING BANDSAW OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
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#PC8297 PRINTED IN TAIWAN



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Foreword

We are proud to offer the Model G0561 7" x 12" Metal-Cutting Bandsaw. This machine is part of a growing Grizzly family of fine metalworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0561. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0561 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G0561 7" X 12" METAL CUTTING BANDSAW

Product Dimensions:

Weight..... 330 lbs.
 Length/Width/Height..... 48 x 16 x 40 in.
 Foot Print (Length/Width)..... 38 x 13 in.

Shipping Dimensions:

Type..... Not Available
 Content..... Machine
 Weight..... 343 lbs.
 Length/Width/Height..... 19 x 51 x 41 in.

Electrical:

Switch..... Automatic Shut Off
 Switch Voltage..... 110V
 Cord Length..... 7 ft.
 Cord Gauge..... 14 gauge
 Plug..... Yes

Motors:

Main

Type..... TEFC Capacitor Start Induction
 Horsepower..... 1 HP
 Voltage..... 110/220V
 Prewired..... 110V
 Phase..... Single
 Amps..... 12/6
 Speed..... 1720 RPM
 Cycle..... 60 Hz
 Number Of Speeds..... 1
 Power Transfer Belt Drive
 Bearings..... Shielded and Lubricated for Life

Main Specifications:

Operation Info

Blade Speeds..... 90, 135, 195, 255 FPM
 Std. Blade Len..... 93 in.

*The information contained herein is deemed accurate as of 6/23/2006 and represents our most recent product specifications.
 Due to our ongoing improvement efforts, this information may not accurately describe items previously purchased.*



Cutting Capacities

Angle Cuts.....	45 - 90 deg.
Vise Jaw Depth.....	9-3/4 in.
Vise Jaw Height.....	4 in.
Max. Capacity Rect. Height At 90D.....	7 in.
Max. Capacity Rect. Width At 90D.....	12 in.
Max. Capacity Rnd. At 90D.....	7 in.
Max. Capacity Rect. Height At 45D.....	4-3/4 in.
Max. Capacity Rect. Height At 30D.....	7-3/4 in.
Max. Capacity Rect. Width At 30D.....	8 in.
Max. Capacity Rnd. At 30D.....	7 in.
Max. Capacity Rect. Width At 45D.....	4-1/2 in.
Max. Capacity Rnd. At 45D.....	5 in.

Construction

Table Construction.....	Cast Iron
Wheel Construction Upper.....	Cast Iron
Wheel Construction Lower.....	Cast Iron
Body Construction.....	Cast Iron
Base Construction.....	Stamped Steel
Wheel Cover Construction.....	Pre-formed Steel
Paint.....	Epoxy

Other

Wheel Size.....	11-1/2 in.
Blade Guides Upper.....	Ball Bearing
Blade Guides Lower.....	Ball Bearing
Coolant Cap.....	2-1/2 GAL

Table Info

Table Size Length.....	20-1/2 in.
Table Size Width.....	6-3/4 in.
Floor To Cutting Area Height.....	21 in.

Other Specifications:

ISO Factory	ISO 9001
Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Machine Label on Body Frame

Features:

- Hydraulic Feed Control
- Quick Positioning Vise
- Automatic Shut off
- Coolant System
- Includes Blade

The information contained herein is deemed accurate as of 6/23/2006 and represents our most recent product specifications. Due to our ongoing improvement efforts, this information may not accurately describe items previously purchased.



Identification

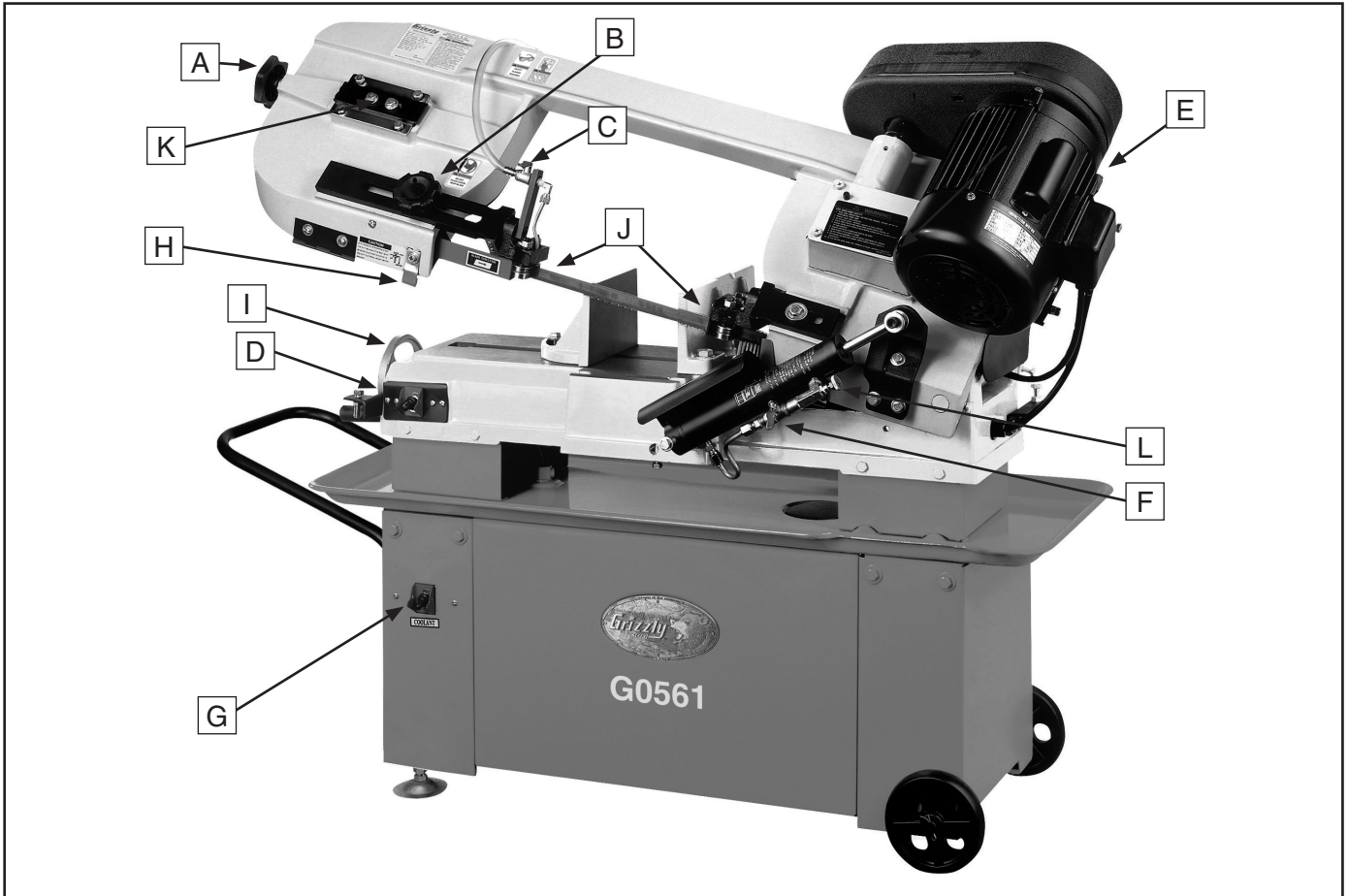


Figure 1. Main view of machine features.

- | | |
|---------------------------------------|-----------------------------------|
| A. Blade Tension Handle | G. Pump ON/OFF Switch |
| B. Blade Guide Adjustment Knob | H. Automatic Shut-Off Tab |
| C. Coolant Control Valve | I. Vise Handwheel |
| D. Motor ON/OFF Switch | J. Blade Guides |
| E. 1 HP Motor | K. Blade Tracking Controls |
| F. Feed ON/OFF Valve Lever | L. Feed Rate Control Knob |




SECTION 1: SAFETY


WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

 **DANGER** Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.

 **WARNING** Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.

 **CAUTION** Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE This symbol is used to alert the user to useful information about proper operation of the machine.

WARNING

Safety Instructions for Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
- 3. ALWAYS WEAR AN NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.**
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **BE AWARE THAT CERTAIN MATERIALS MAY CAUSE AN ALLERGIC REACTION** in people and animals, especially when exposed to fine dust. Make sure you know what type of dust you will be exposed to and always wear an approved respirator.



WARNING

Safety Instructions for Metal Cutting Bandsaws

- 1. BLADE CONDITION.** Do not operate with dull, cracked or badly worn blade. Inspect blades for cracks and missing teeth before each use.
- 2. HAND PLACEMENT.** Never position fingers or thumbs in line with the cut.
- 3. ENTANGLEMENT HAZARDS.** Do not operate this bandsaw without guards in place. Loose clothing, jewelry, long hair and work gloves can be drawn into working parts.
- 4. BLADE REPLACEMENT.** When replacing blades, make sure teeth face toward the workpiece. Wear gloves to protect hands and safety glasses to protect eyes.
- 5. WORKPIECE HANDLING.** Always support the workpiece with table, vise, or some type of support fixture. Flag long pieces to avoid a tripping hazard. Never hold the workpiece with your hands during a cut.
- 6. LOSS OF STABILITY.** Unsupported workpieces may jeopardize machine stability and cause the machine to tip and fall which could cause serious injury.
- 7. POWER INTERRUPTION.** Unplug or turn off machine after power interruption. Machines without magnetic switches can start up after power is restored.
- 8. FIRE HAZARD.** Use EXTREME CAUTION if cutting magnesium. Using the wrong cutting fluid will lead to a chip fire and possible explosion.
- 9. CUTTING FLUID SAFETY.** Always follow manufacturer's cutting-fluid safety instructions. Pay particular attention to contact, contamination, inhalation, storage and disposal warnings. Spilled cutting fluid invites slipping hazards. Never plug or unplug bandsaw with wet hands or while standing in liquids of any kind.
- 10. ATTENTION TO WORK AREA.** Never leave a machine running and unattended. Pay attention to the actions of others in the area to avoid unintended accidents.
- 11. MAINTENANCE/SERVICE.** All inspections, adjustments, and maintenance are to be done with the power **OFF** and the plug pulled from the outlet. Wait for all moving parts to come to a complete stop.
- 12. HEARING PROTECTION & HAZARDS.** Noise generated by blade and workpiece vibration, material handling, and power transmission can cause permanent hearing loss over time and interfere with communication and audible signals.
- 13. HOT SURFACES.** Contact with hot surfaces from machine components, ejections of hot chips, swarf and workpiece can cause burns.

WARNING

No list of safety guidelines can be complete. Every shop environment is different. Like all machines there is danger associated with the Model G0561. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.



SECTION 2: CIRCUIT REQUIREMENTS

110/220V Operation

⚠️ WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the setup process. **DO NOT** connect the machine to the power source until instructed to do so.

Amperage Draw

The Model G0561 features 110/220V motor that is prewired for 110V and draws the following amps under maximum load:

Motor Draw at 110V 16 Amps
Motor Draw at 220V 8 Amps

Circuit Requirements

We recommend connecting this machine to a dedicated circuit with a verified ground, using the circuit size given below. Never replace a circuit breaker with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, you may create a fire hazard—consult a qualified electrician to reduce this risk.**

110V Circuit 20 Amps
220V Circuit 15 Amps

Wiring for 220V

The Model G0561 can be rewired to operate on a 220V power source. The motor must be rewired according to the wiring diagram on the motor label. The wiring configuration can also be found on the inside of the motor wire cover, as well as on **Page 38**.

Plug Type

The Model G0561 comes prewired with a NEMA 5-15 plug. If you wish to rewire the motor to 220V you will need the following 220V plug (see **Figure 2** for an example):

220V Plug & Receptacle 6-15

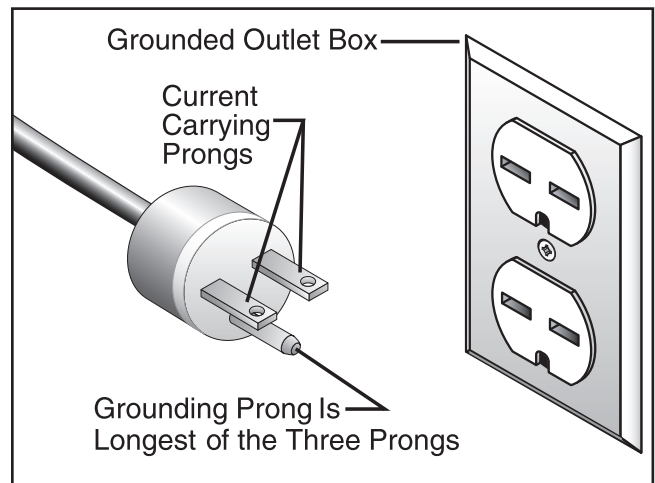
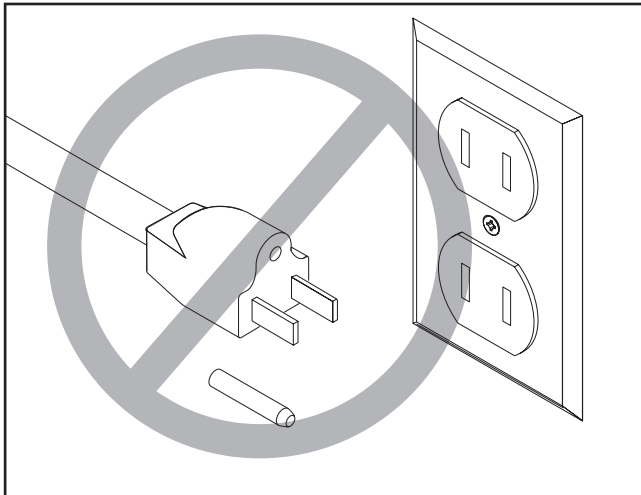
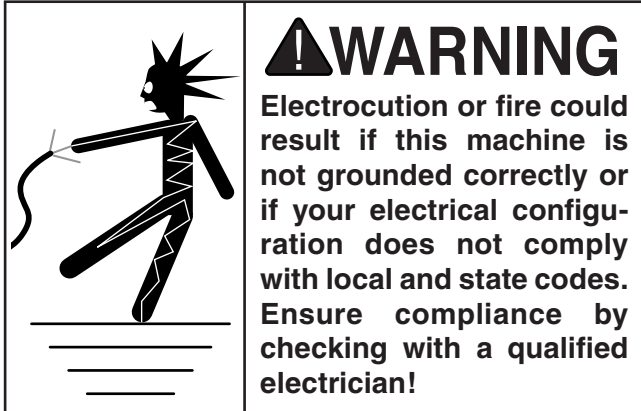


Figure 2. 6-15 plug and outlet.



Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. The grounding wire in the power cord must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded. All electrical connections must be made in accordance with local codes and ordinances.



! CAUTION

This machine must have a ground prong in the plug to help ensure that it is grounded. **DO NOT** remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.

Extension Cords

We do not recommend the use of extension cords. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

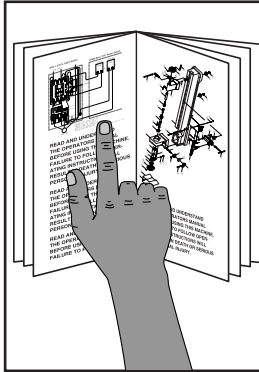
If you find it absolutely necessary to use an extension cord at 110V with your machine:

- Use at least a 12 gauge cord for 110V or 16 gauge cord for 220V that does not exceed 50 feet in length!
- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician **MUST** size cords over 50 feet long to prevent motor damage.

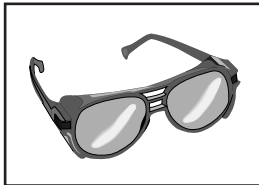


SECTION 3: SETUP

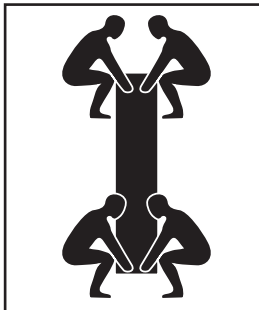
Setup Safety



!WARNING
This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



!WARNING
Wear safety glasses during the entire setup process!



!WARNING
The Model G0561 is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

Items Needed for Setup

The following items are needed to complete the setup process, but are not included with your machine:

Description	Qty
• Wrench 3/4"	1
• Wrench 14mm	1
• Safety Glasses (for each person)	1
• Helpers	3
• Phillips Head Screwdriver #2	1
• Level	1

Unpacking

The Model G0561 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advise.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the contents.



Inventory

After all the parts have been removed from the box, you should have the following items:

Box Contents (Figure 3)	Qty
Metal-Cutting Bandsaw (not shown)	1
A. Wheels	2
B. Axle	1
C. Leveling Feet with Hex Nuts	2
D. Chip Screen.....	1
E. Work Stop.....	1
F. Work Stop Rod.....	2
G. Vertical Work Table.....	1
H. Table Bracket	1
I. Handle	1
J. Pulley Cover.....	1
K. Collar	1

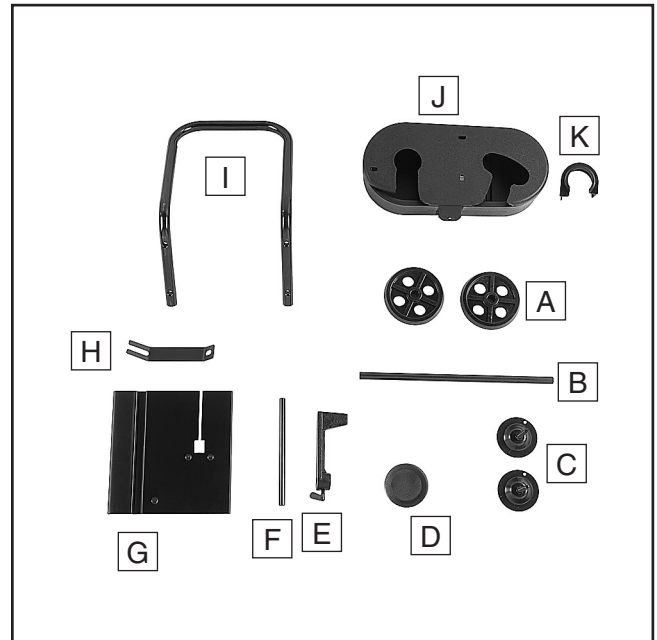


Figure 3. Loose parts inventory.

Hardware Bag

- Flat Washers $\frac{3}{8}$ " (Leveling Feet)..... 2
- Cotter Pins 3 x 30 (Wheels)..... 2
- Hex Bolts $\frac{5}{16}$ "-18 x $1\frac{1}{2}$ (Handle)..... 4
- Hex Nuts $\frac{5}{16}$ "-18 (Handle)..... 4
- Flat Washers $\frac{5}{16}$ " (Handle)..... 8
- Wire Nuts (for 220V Wiring)..... 2
- Flat Head Screw $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " (Table)..... 1
- Hex Nut $\frac{1}{4}$ " x 20 (Table)..... 1
- Phillips Head Screws $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " (Pulley Cover)..... 2
- Flat Washers $\frac{1}{4}$ " (Pulley Cover)..... 4
- Knob $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " (Pulley Cover)..... 1
- Hex Nuts $\frac{3}{8}$ "-16..... 2

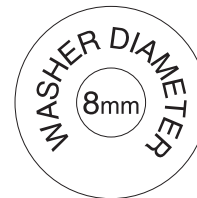
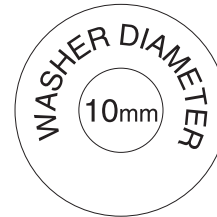
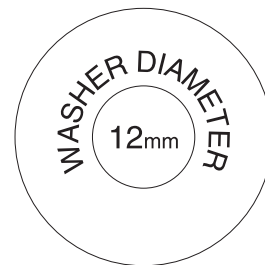
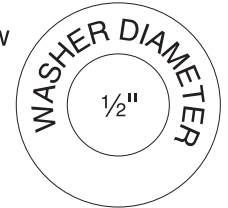
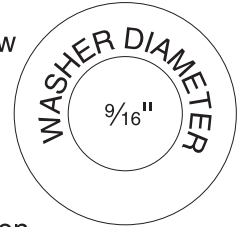
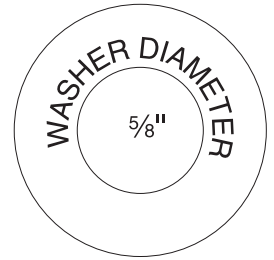
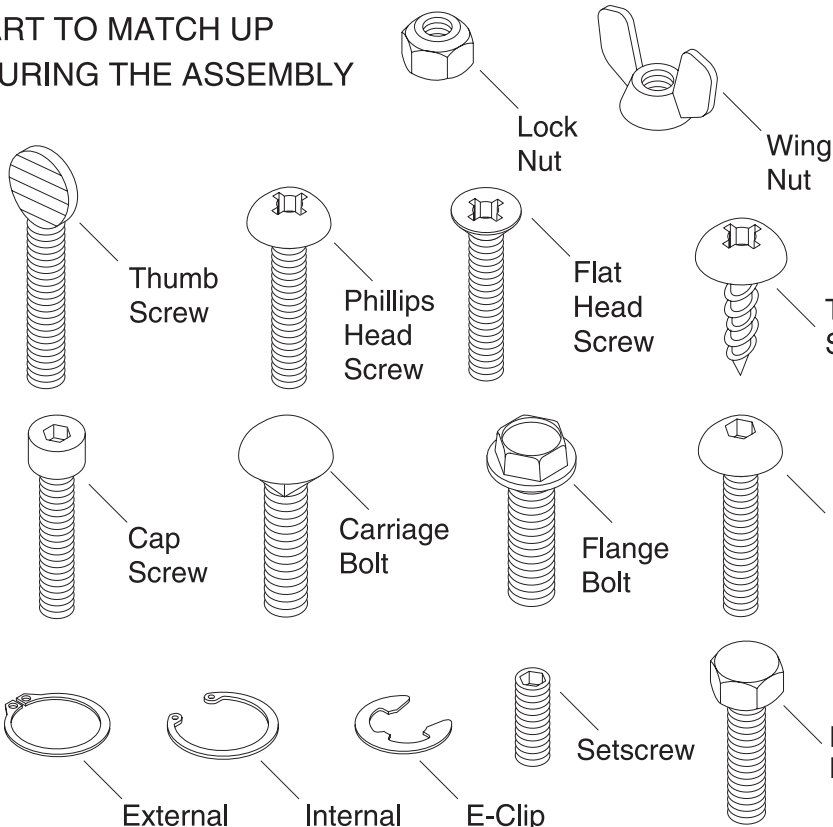


Hardware Recognition Chart

USE THIS CHART TO MATCH UP
HARDWARE DURING THE ASSEMBLY
PROCESS!

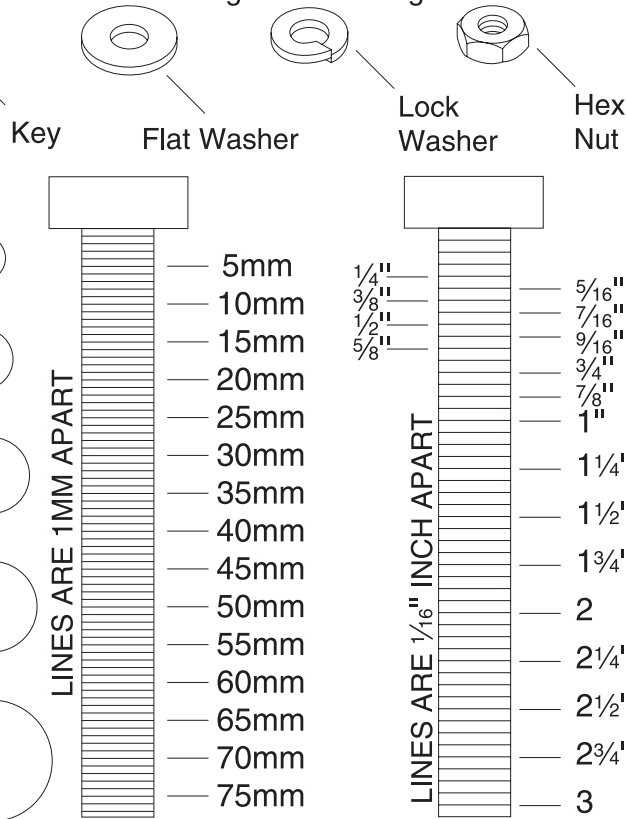
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"



#10

- 4mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm




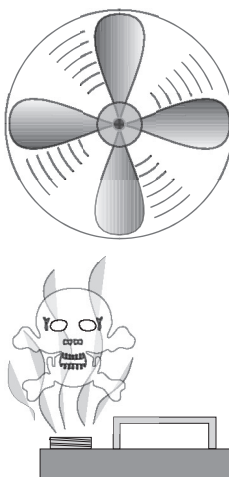
WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Cleanup

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner, as they will damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

	<p>⚠ WARNING Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.</p>
--	---

	<p>⚠ CAUTION Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.</p>
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Site Considerations

Floor Load

The weight and footprint size for your machine is located in the machine data sheet. Most floors are suitable for your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 4** for the minimum working clearances.

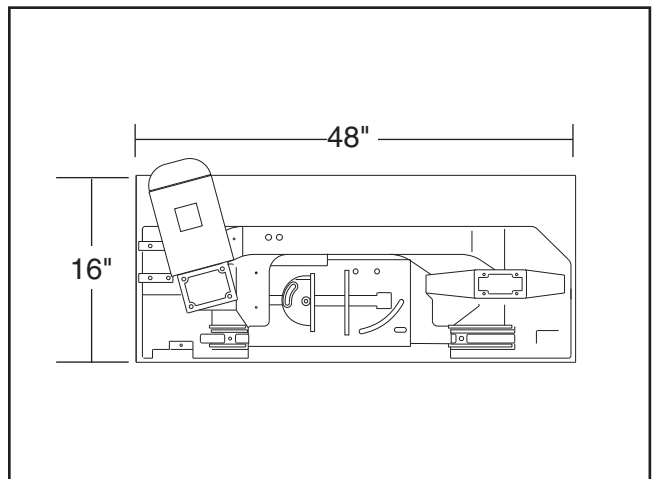


Figure 4. Minimum G0561 working clearances.

	<p>⚠ CAUTION Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!</p>
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Shipping Bracket

A shipping bracket has been installed on the bandsaw to protect the alignment of the bow during shipment. After removal, store the bracket in a safe place until you need to move or ship the bandsaw in the future.

To remove the shipping bracket:

1. Use a #2 Phillips head screwdriver to remove the top screw and flat washer, use a 14mm wrench to loosen the bottom hex nut and remove the shipping bracket shown in **Figure 5**.

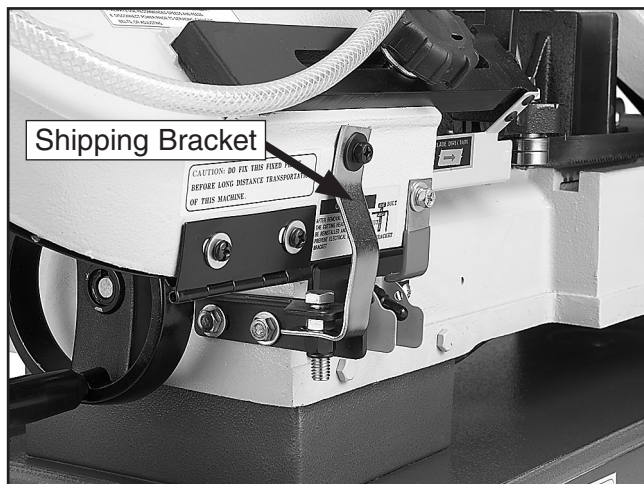


Figure 5. Removing shipping bracket.

Work Stop

Components and Hardware Needed:	Qty
Work Stop.....	1
Work Stop Rod.....	1

To install the work stop:

1. Insert the work stop rod through the hole in the base shown in **Figure 6** and lock in place with the hex bolt.

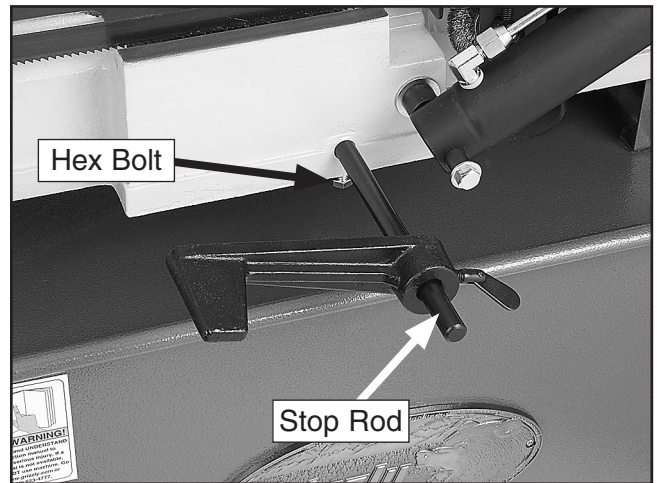


Figure 6. Installed work stop.

2. Slide the work stop over the rod.
3. Measuring from the outside of the blade, tighten the thumbscrew to set the work stop at your desired length.



Wheels & Leveling Feet

The wheels may be installed to make it easier to move the G0561 bandsaw.

Components and Hardware Needed:	Qty
Wheels.....	2
Axle	1
Cotter Pins 3 x 30mm.....	2
Leveling Feet with Hex Nuts	2
Flat Washers 10mm	2

To install the wheels and leveling feet:

1. Slide the axle through the holes in the bottom of the cabinet.
2. Slide the wheels on the axle and secure with the two cotter pins as shown in **Figure 7**.

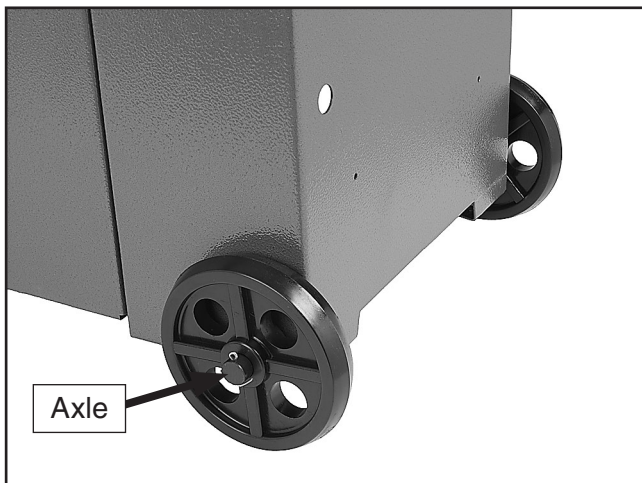


Figure 7. Wheels installed.

3. Screw the threaded portion of the leveling feet, followed by the flat washer and hex nut, into the base of the cabinet as shown in **Figure 8**.
4. Adjust the feet to level the bandsaw as needed.

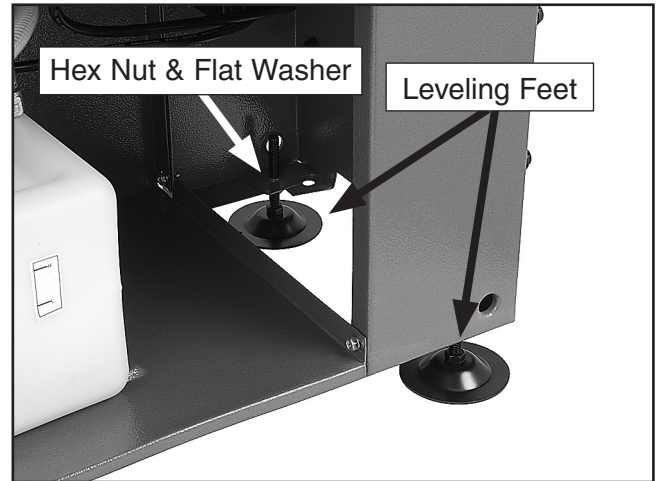


Figure 8. Leveling feet installed.

Chip Screen

The chip screen is designed to prevent chips and cut-offs from entering the coolant tank.

Components and Hardware Needed:	Qty
Chip Screen.....	1

To install the chip screen:

1. Place the chip screen into the opening shown in **Figure 9**.

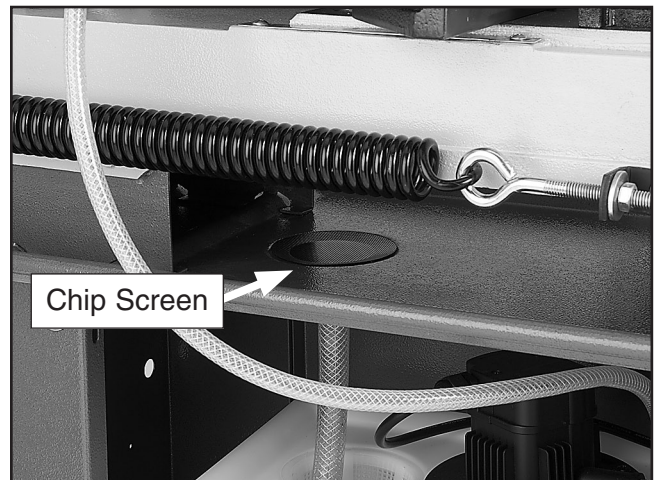


Figure 9. Chip screen installed.



Pulley Cover

Components and Hardware Needed:	Qty
Pulley Cover	1
Collar	1
Phillips Head Screws 1/4"-20 x 5/8"	2
Flat Washers 1/4"	2
Knob 1/4"-20 x 5/8"	1

To install the pulley cover:

1. Slide the collar onto the bottom side of the pulley cover and snap in place as shown in **Figure 10**.

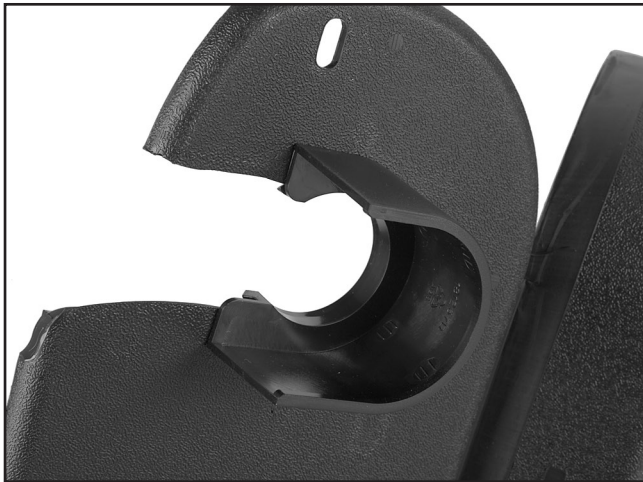


Figure 10. Collar installed.



Figure 11. Installing pulley cover.

2. Slide the pulley cover over the pulleys.
3. Align the holes and secure with the two 1/4"-20 x 5/8" Phillips head screws and four flat washers (see **Figure 11**).



Figure 12 Secured pulley cover lid.

4. Close the pulley cover lid and secure with the knob (see **Figure 12**).



V-Belt

The V-Belt on the Model G0561 may have come installed and only need to be tensioned or repositioned for your desired RPM. The following steps will take you through both processes.

To tension or change the V-belt position:

1. UNPLUG THE BANDSAW!
2. Loosen but do not remove the two hex bolts on the bottom of the motor mount (see **Figure 13**).

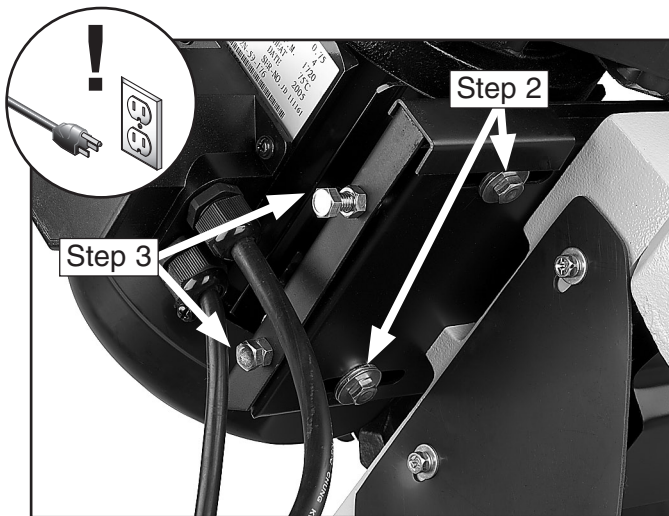


Figure 13. V-Belt tension hex bolts.

3. Adjust the two hex bolts on the outer edge of the motor mount to either loosen or tension the belt (see **Figure 13**).
4. Slip the V-belt over the combination of pulleys to get the desired RPM. Make sure the belt is on parallel sheaves. See the chart on the inside of the pulley cover for RPM choices.
5. Re-tension the belt. Apply enough tension so the belt deflects about 1/2" with moderate pressure when pinched together between the center of the pulleys.

Handle

Components and Hardware Needed:	Qty
Handle	1
Hex Bolts 5/16"-18 x 1 1/2"	4
Flat Washers 5/16"	8
Hex Nuts 5/16"-18	4

To install the handle:

1. Attach the handle to the cabinet with hex bolts, washers, and hex nuts as shown in **Figure 14**.

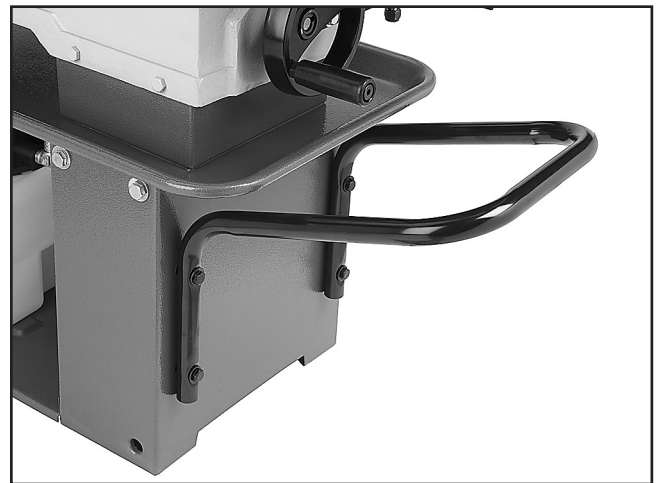


Figure 14. Handle installed.



Vertical Assembly

The Model G0561 can easily be set up for vertical cutting operations.

Components and Hardware Needed:	Qty
Vertical Work Table.....	1
Table Bracket.....	1
Flat Head Screw $\frac{1}{4}$ "-20 x $\frac{3}{8}$ ".....	1
Hex Nut $\frac{1}{4}$ "-20.....	1

To assemble the bandsaw for vertical cutting:

1. Remove the two screws and blade guide cover as shown in **Figure 15**.

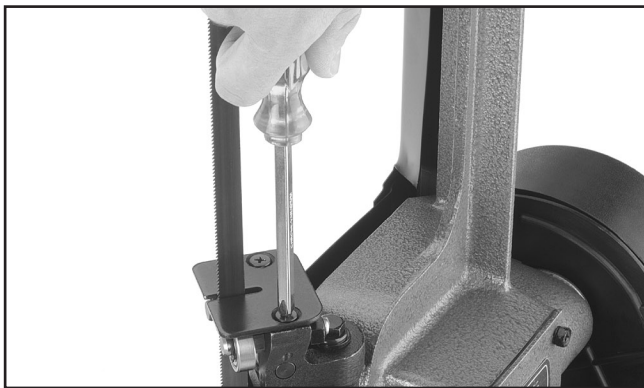


Figure 15. Removing blade guide cover.

2. Install the vertical work table and replace the two screws removed in **Step 1**.
3. Install the table bracket shown in **Figure 16** with the bolt already in the casting.

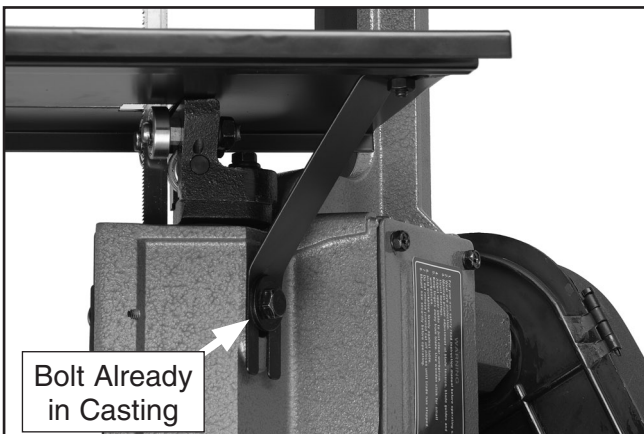


Figure 16. Table and bracket installed.

4. Set a square to the side of the blade, as shown in **Figure 17**, and adjust the table bracket to square the table to the blade.

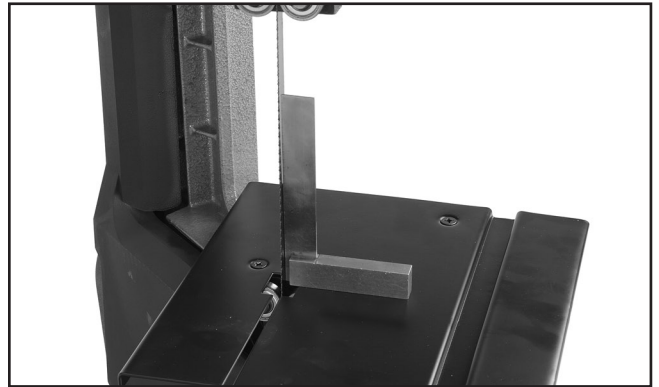


Figure 17. Squaring table to blade.

5. Place a level on the table, as shown in **Figure 18**, and turn the adjustment bolt shown in **Figure 19** until the table is level.

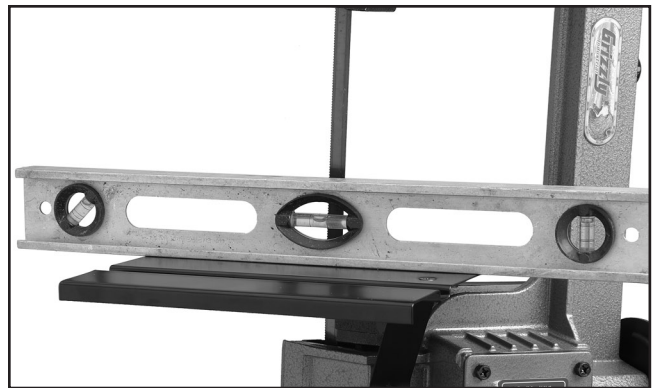


Figure 18. Adjusting table level.



Figure 19. Adjustment bolt.

6. Close the feed ON/OFF valve to lock the bow in position (see **Figure 20**).



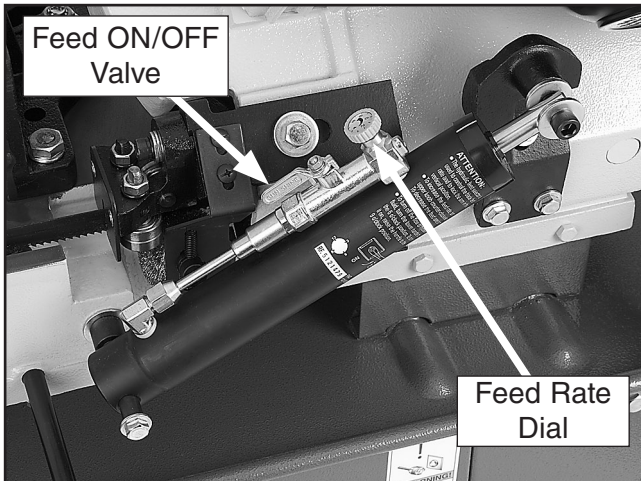



Figure 20. Feed ON/OFF valve and feed rate dial.

Test Run

	<p>⚠ WARNING Metal chips thrown from the machine could cause serious eye injury. Wear safety glasses during assembly and operation.</p>
--	--

Starting the machine:

1. Read the entire instruction manual.
2. Make sure all tools and foreign objects have been removed from the machine.
3. Put on safety glasses and secure loose clothing or long hair.
4. Connect the bandsaw to power.
5. Raise the bandsaw and close the feed ON/OFF valve to keep the saw in place (see **Figure 20**).
6. Start the bandsaw while keeping your finger near the ON/OFF switch at all times during the test run (**Figure 21**). The bandsaw should run smoothly with little or no vibration.

—If you suspect any problems, immediately stop the bandsaw and correct before continuing.

—If you need any help with your bandsaw call our Tech Support at (570) 546-9663.

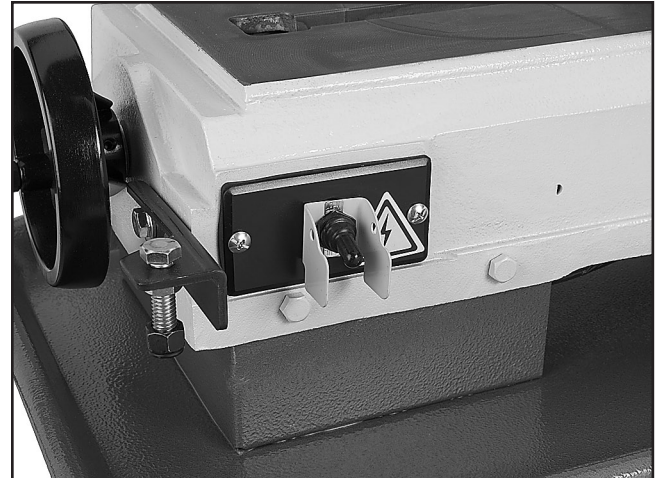


Figure 21. ON/OFF switch.

Recommended Adjustments

The adjustments listed below have been performed at the factory. However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure accurate cutting results.

Step-by-step instructions on verifying these adjustments can be found in **SECTION 7: SERVICE ADJUSTMENTS**.

Factory adjustments that should be verified:

1. Blade Tension & Tracking (**Page 34**).
2. Squaring the Blade (**Page 35**).
3. Blade Guide Bearings (**Page 36**).

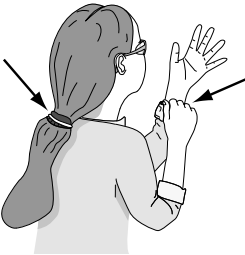
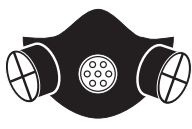


SECTION 4: OPERATIONS

Operation Safety

!WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



!WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Vise

The vise can hold material up to six inches wide and be set to cut angles from 0 to 45 degrees.

To square the blade to the vise:

1. Loosen the lock nut shown in **Figure 22** with a $\frac{3}{4}$ " wrench or socket.
2. Use the scale as a guide to set your angle, or use a machinist square to square the blade to the vise.
3. Tighten the lock nut.

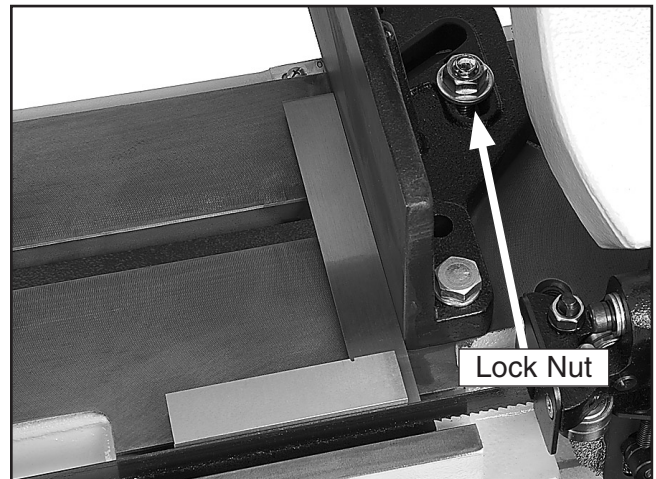


Figure 22. Squaring vise to blade.



To adjust the angle on the vise:

1. Loosen the lock nut on the rear jaw with a 3/4" hex wrench.
2. Use the scale to set your angle (see **Figure 23**).
3. Tighten the lock nut.

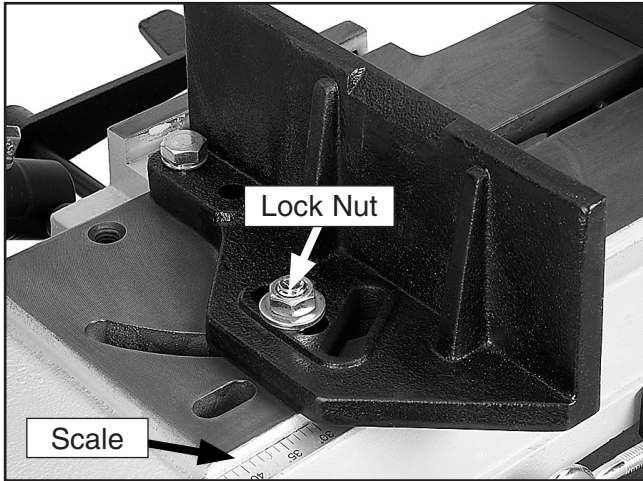


Figure 23. Vise angle adjustments.

4. Loosen the lock nut in **Figure 24** on the opposite jaw so the jaw can float, and match the angle of the workpiece.
5. Tighten the vise against the workpiece.

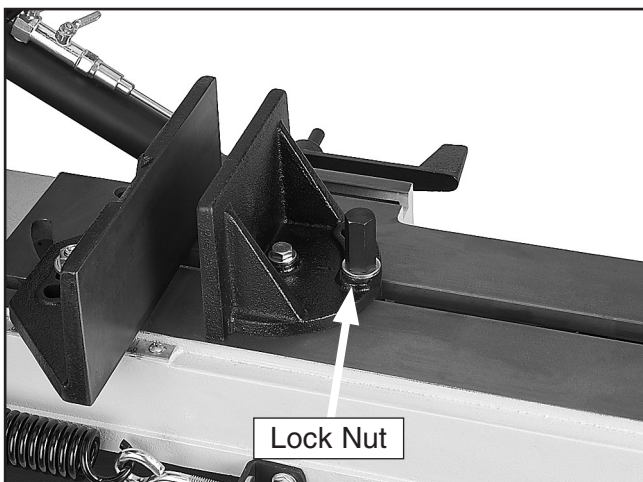


Figure 24. Vise jaw lock nut.

Blade Speed

The Model G0561 has four blade speeds: 80, 130, 180, and 235 FPM.

To change blade speeds:

1. UNPLUG THE BANDSAW!
2. Determine the best speed for your cut. The table in **Figure 25** is provided as a rough guideline. Material thickness and the type of blade used will factor into FPM selection.

Material	Feet Per Minute (FPM)
Aluminum	250
Plastics	800
Brass (soft)	500
Carbon Tool Steel	100-150
Cast Iron	100-150
Cold Rolled Steel	150-200
High Speed Steel	90-125
Malleable Iron	150-200
Hard Rubber	150-200

Figure 25. Blade speed table.

3. Slacken the V-belt and position on the pulley for the desired FPM (see **Figure 26**).

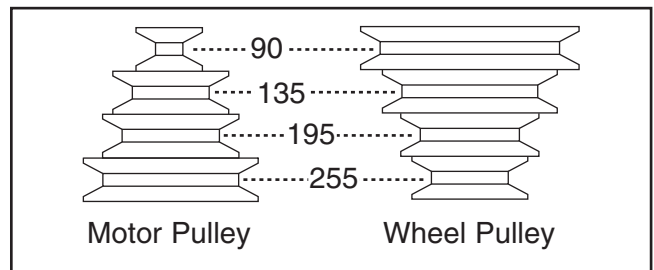


Figure 26. V-belt positions in FPM.

4. Tension the V-belt as described in the **V-Belt** section on **Page 19**.

Continued on next page →



Blade Selection

The Model G0561 uses 93" x 3/4" bandsaw blades.

Selecting the right blade for the job depends on a variety of factors, such as the type of material being cut, hardness of the material, machine capability, and operator technique.

We suggest you do some research for your specific situation so you get the best blade to match your needs.

Grizzly is proud to offer a variety of selections that can be found in the current catalog and in **SECTION 5: ACCESSORIES on Page 28.**

Blade Guides

The blade guides should be as close to the workpiece as possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off the cut line.

To adjust the blade guides:

1. Loosen the knob shown in **Figure 27** and slide the rear blade guide as close to the workpiece as possible, then tighten the knob.

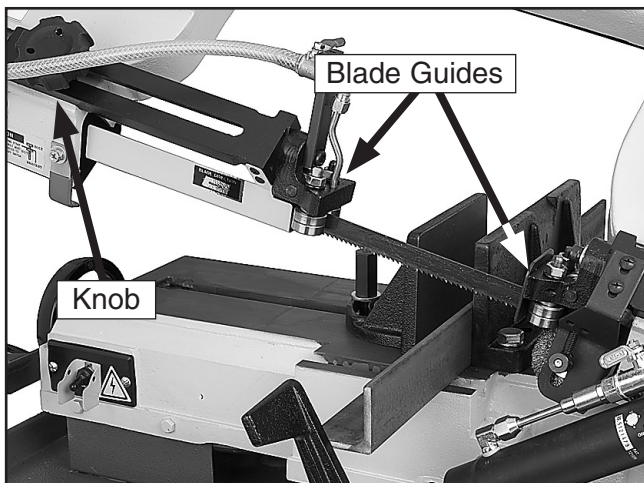


Figure 27. Blade guides.

Cutting Fluid System



This bandsaw has a built-in cutting fluid system that extends the life of your bandsaw blades by lowering the cutting temperature and washing away chips.

See **Cutting Fluid on Page 25** for more information.

To use the cutting fluid system:

1. Thoroughly clean and remove any foreign material that may have fallen inside the reservoir during shipping.
2. Place the filter screen and drain tube in the reservoir as shown in **Figure 28.**
3. Fill the reservoir to the "High" mark with your chosen cutting fluid solution.

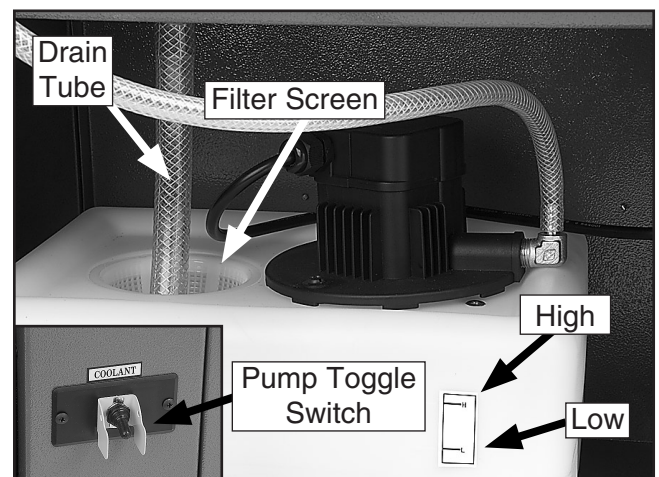


Figure 28. Filter screen and hose.



	<p>!WARNING FIRE HAZARD! DO NOT cut magnesium when using oil-water solutions as a cutting fluid! Always use a cutting fluid intended for magnesium. The water in the solution will cause a magnesium-chip fire.</p>
---	--

- Adjust the valve on the coolant hose to control the flow of coolant (see **Figure 29**). Make sure that the pressure is not so high that coolant spills on the floor and creates a slipping hazard.

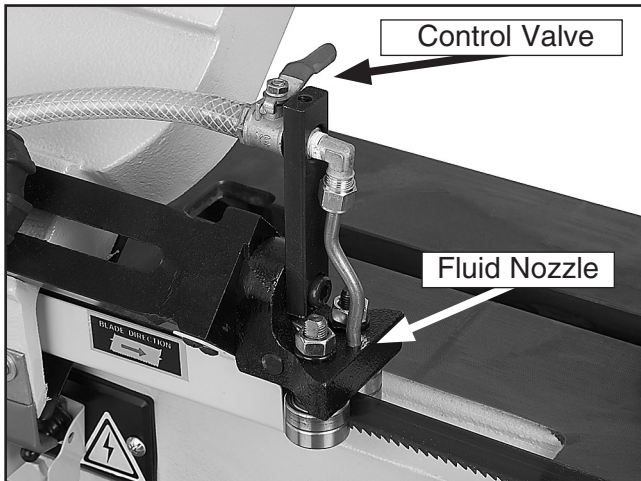


Figure 29. Coolant control valve.

- Turn the pump toggle switch **ON** before making your cut.

<p style="text-align: center;">NOTICE</p> <p>Keep the tray chip screen clear so coolant can recycle to the pump reservoir. NEVER operate the pump with the reservoir below the low mark or you will over-heat the pump and void your warranty!</p>
--


Cutting Fluid

While simple in concept and function, many issues must be taken into account to find and use the correct cutting fluid. Always follow all product warnings and contact the fluid manufacturer for unanswered questions.

Use the selections below to choose the appropriate cutting fluids:

- For cutting low alloy, low carbon, and general-purpose category metals with a bi-metal blade—use a water soluble cutting fluid.
- For cutting stainless steels, high carbon, and high alloy metals, brass, copper and mild steels—use "Neat Cutting Oil" (commonly undiluted mineral oils) that have extreme pressure additives (EP additives).
- For cutting cast iron, cutting fluid is not recommended.
- For cutting magnesium, use only cutting fluid that is designed for cutting this material.

Remember: Too much flow at the cutting fluid nozzle will make a mess and can make the work area unsafe; and not enough fluid at the cut will heat the blade, causing the blade teeth to load up and break.

	<p>!WARNING BIOLOGICAL AND POISON HAZARD! Use proper personal protection equipment when handling cutting fluid and dispose by following federal, state, and fluid manufacturer requirements to properly dispose of cutting fluid.</p>
--	--



Feed Rate

The speed at which the saw blade will cut through a workpiece is controlled by blade type, feed rate, and feed pressure.

Note: If a lubricant is used on the cut, the feed rate can be increased by approximately 15%.

To set the feed rate:

1. Raise the bow to the maximum height to remove spring tension. Close the ON/OFF valve to lock the bow in place.
2. Using a $\frac{9}{16}$ " wrench, adjust the feed pressure tension spring. Tighten enough to remove play but not enough to apply tension to the spring (see **Figure 30**).

Note: This spring adjustment is an initial setting. Depending on cutting circumstances, you will have to fine-tune the feed pressure with this adjustment. Increasing the spring tension will reduce the feed pressure.

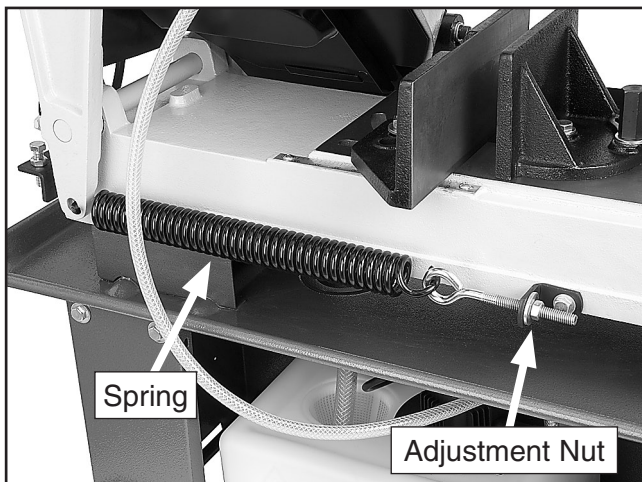


Figure 30. Spring tension adjustment.

3. Clamp the workpiece in the table vise.
4. Close the feed ON/OFF valve shown in **Figure 31**, to lock the bow and blade a few inches above the workpiece.

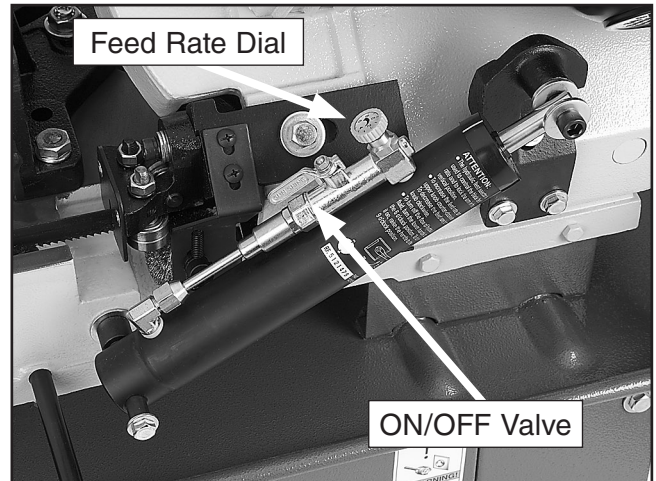


Figure 31. Feed rate dial.

5. With the correct saw blade and blade speed selected, turn the saw and lubricant pump **ON**.
6. Open the ON/OFF valve, then slowly rotate the feed rate dial clockwise to a slow feed rate until the saw begins to cut the workpiece (see **Figure 31**).
7. Observe the chips that exit the cut, and increase or decrease the feed rate according to the chip characteristics.
 - If you get a tightly curled, warm shavings, brown to black in color, you are using too much downward pressure.
 - Blue looking chips are caused by extreme heat from too high blade speed.
 - Thin powder-like chips are from insufficient feed pressure. This will dull your blade rapidly.
 - The best cut and feed rate will give you evenly shaped spiraled curls with very little color change, if any at all.



Operation Tips

The following tips will help you safely and effectively operate your bandsaw, and help you get the maximum life out of your saw blades.

Tips for horizontal cutting:

- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length.
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material.
- Let the blade reach full speed before engaging the workpiece. Never start a cut with the blade in contact with the workpiece (see **Figure 32**).

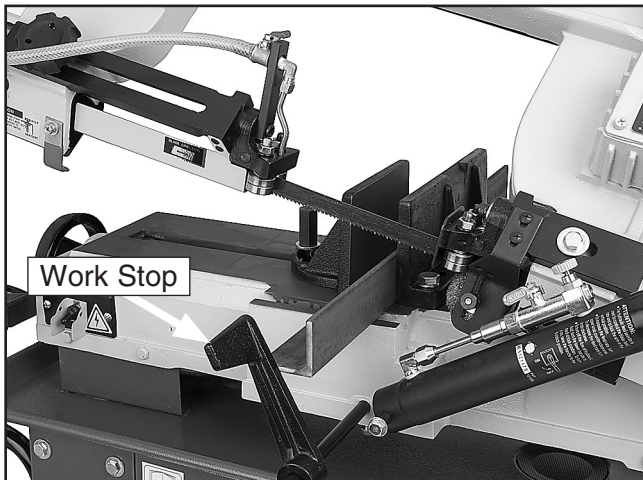


Figure 32. Proper starting position.

NOTICE

Loosen blade tension at the end of each day to prolong blade life.

- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!
- Support long workpieces so they won't fall when cut, and flag the end of workpieces to alert passers-by of potential danger.
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.
- Use coolant when possible to increase blade life.

Tips for vertical cutting:

- Make sure that the vertical table assembly is securely fastened to the bandsaw frame so it will adequately support the workpiece.
- Always keep your fingers away from the blade and always hold the workpiece securely with the appropriate clamping device.
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.



SECTION 5: ACCESSORIES

- G5124—93 x 3/4 x .032 10 TPI Raker
- G5125—93 x 3/4 x .032 14 TPI Raker
- G5126—93 x 3/4 x .032 18 TPI Raker
- G5127—93 x 3/4 x .032 4-6 Variable Pitch
- G5128—93 x 3/4 x .032 5-8 Variable Pitch
- G5129—93 x 3/4 x .032 6-10 Variable Pitch
- G5130—93 x 3/4 x .032 8-12 Variable Pitch
- G5131—93 x 3/4 x .032 10-14 Variable Pitch

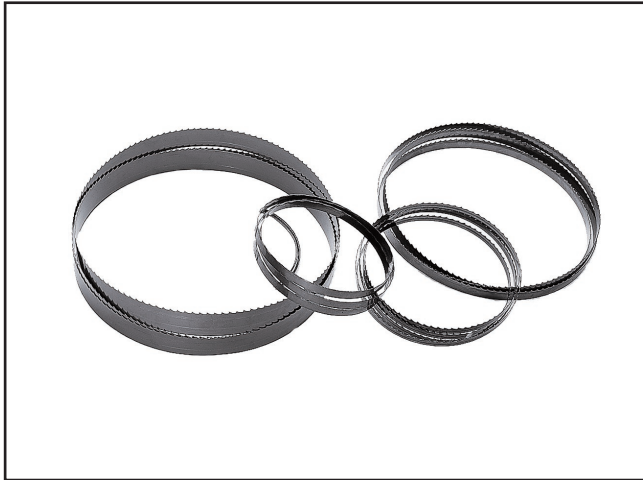


Figure 33. Blades

H5408—Blade Tensioning Gauge

The Blade Tensioning Gauge ensures long blade life, reduced blade breakage, and straight cutting by indicating correct tension. A precision dial indicator provides you with a direct readout in PSI.



Figure 34. H5408 Blade Tensioning Gauge.

H5405—Lenox® Lube Tube™

Lenox® Lube Tube™ is a stick lubricant designed to prevent heat buildup. Apply it directly to the blade to improve overall blade life and productivity. Can be used on ferrous and non-ferrous metals. Biodegradable, non-toxic, and non-staining 14.5 oz tube.



Figure 35. Lenox® Lube Tube™.

G7897—Machining Fluid

This biostable, soluble oil for heavy-duty machining applications provides stable pH performance which resists bacteria, fungal growth, rancidity and odors. Can be used in light or heavy machining. Mix with water, 1:21 for general use or 1:11-1:16 for heavy use.



Figure 36. G7897 Machining Fluid.

Call 1-800-523-4777 To Order



G5618—Deburring Tool with Two Blades

G5619—Extra Aluminum Blades

G5620—Extra Brass and Cast Iron Blade

The quickest tool for smoothing freshly machined metal edges. Comes with two blades—one for steel/aluminum and one for brass/cast iron.



Figure 37. G5618 Deburring tool.

H1302—Standard Earmuffs

H4979—Deluxe Twin Cup Hearing Protector

H4977—Work-Tunes Radio Headset Earmuffs

Protect yourself comfortably with a pair of cushioned earmuffs. Especially important if you or employees operate for hours at a time.



Figure 39. Our most popular earmuffs.

G7984—Face Shield

H1298—Dust Sealed Safety Glasses

H1300—UV Blocking, Clear Safety Glasses

H2347—Uvex® Spitfire Safety Glasses

H0736—Shop Fox® Safety Glasses

Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!

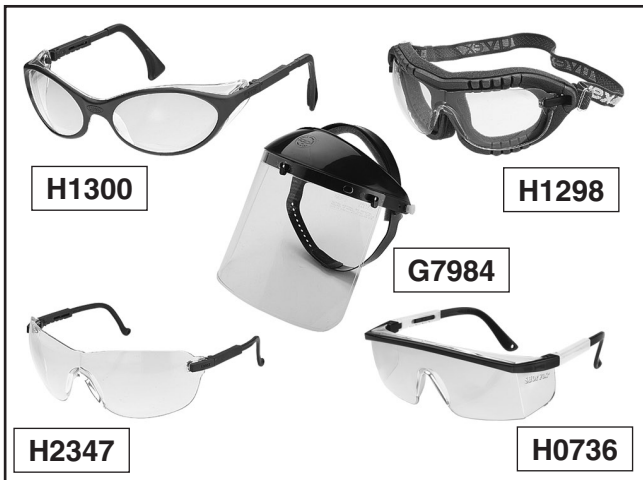


Figure 38. Our most popular safety glasses.

G9256—6" Dial Caliper

G9257—8" Dial Caliper

G9258—12" Dial Caliper

These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display.

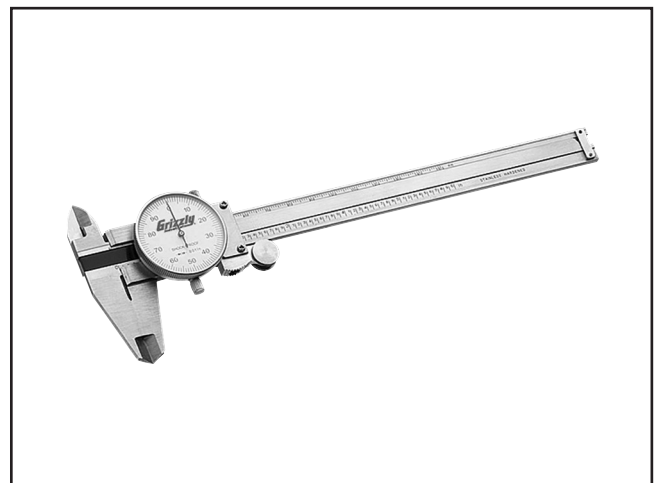
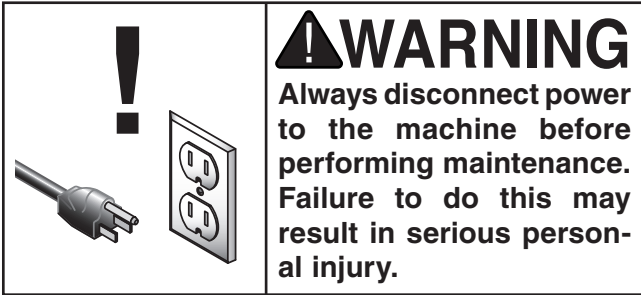


Figure 40. Grizzly® Dial Calipers.

Call 1-800-523-4777 To Order



SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.
- Clean after each use.
- Proper blade tension.

Monthly Check:

- Lubricate vise screw.
- Check gear box lubrication.

Cleaning

Cleaning the Model G0561 is relatively easy. After using your bandsaw, sweep off excess chips and remove any excess coolant with a dry towel.

Lubrication

Before applying lubricant to any area, wipe the area clean to avoid contamination. Lubricate the vise screw shown in **Figure 41** with general purpose grease.

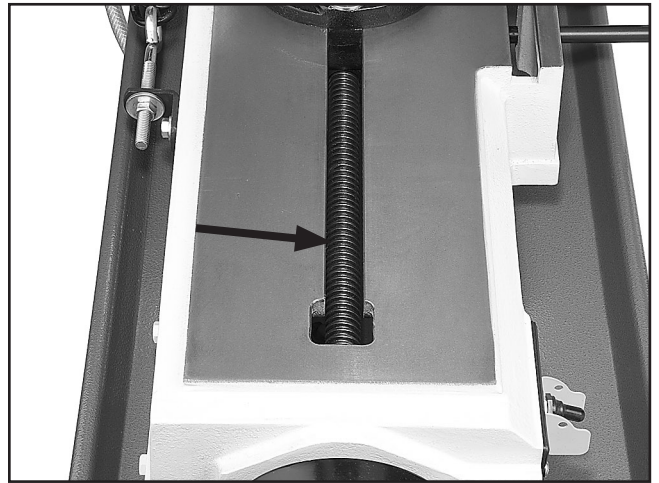


Figure 41. Vise screw lubrication area.

Remove the cover on the gear box in **Figure 42** and coat the gears with general purpose grease.



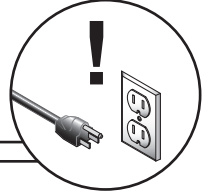
Figure 42. Gear box lubrication.



SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting

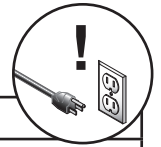


Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Plug/receptacle is at fault or wired incorrectly. 2. Start capacitor is at fault. 3. Wall fuse/circuit breaker is blown/tripped. 4. Motor connection wired incorrectly. 5. Power supply is at fault/switched OFF. 6. Motor ON/OFF switch is at fault. 7. Wiring is at fault. 8. Motor is at fault. 	<ol style="list-style-type: none"> 1. Test for good contacts; correct the wiring. 2. Test/replace if faulty. 3. Ensure correct size for machine load; replace weak breaker. 4. Correct motor wiring connections. 5. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. 6. Replace faulty ON/OFF switch. 7. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 8. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Wrong blade for the workpiece material. 2. Wrong workpiece material. 3. Feed rate/cutting speed too fast for task. 4. Blade is slipping on wheels. 5. Low power supply voltage. 6. Motor bearings are at fault. 7. Plug/receptacle is at fault. 8. Motor connection is wired incorrectly. 9. Motor has overheated. 10. Motor is at fault. 	<ol style="list-style-type: none"> 1. Use blade with correct properties for your type of cutting. 2. Use metal with correct properties for your type of cutting. 3. Decrease feed rate/cutting speed. 4. Adjust blade tracking and tension. 5. Ensure hot lines have correct voltage on both legs. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 7. Test for good contacts; correct the wiring. 8. Correct motor wiring connections. 9. Clean off motor, let cool, and reduce workload. 10. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor fan is rubbing on fan cover. 2. Blade is at fault. 3. Gearbox is at fault. 4. Wrong blade & too slow of speed. 	<ol style="list-style-type: none"> 1. Replace dented fan cover; replace loose/damaged fan. 2. Replace/resharpen blade. 3. Rebuild gearbox for bad gear(s)/bearing(s). 4. Change blade and or speed.



Bandsaw Operations



SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine is loud when cutting or bogs down in the cut.	<ol style="list-style-type: none"> 1. Excessive feed rate. 2. The blade TPI is too great, or the material is too coarse. 	<ol style="list-style-type: none"> 1. Refer to Feed Rate on Page 26, or Changing Blade Speed on Page 23, and adjust as required. 2. Refer to Blade Selection on Page 24 and adjust as required.
Blades break often.	<ol style="list-style-type: none"> 1. Blade is not tensioned correctly. 2. The workpiece is loose in the vise. 3. The feed or cut speed is wrong. 4. The blade TPI is too great, or the material is too coarse. 5. The blade is rubbing on the wheel flange. 6. The bandsaw is being started with the blade resting on the workpiece. 7. The guide bearings are misaligned, or the blade is rubbing on the wheel flange. 8. The blade is too thick, or the blades are of low quality. 	<ol style="list-style-type: none"> 1. Check to see that blade is not excessively tight or too loose. 2. Clamp the workpiece tighter, or use a jig to hold the workpiece. 3. Refer to Feed Rate on Page 26, or Changing Blade Speed on Page 23, and adjust as required. 4. Refer to Blade Selection on Page 24, and adjust as required. 5. Refer to Blade Tracking on Page 34, and adjust as required. 6. Start bandsaw and then slowly lower the bow by setting the feed rate. 7. Refer to Blade Tracking on Page 34, or Blade Guides on Page 24, and adjust as required. 8. Use a higher quality blade.
Blade dulls prematurely.	<ol style="list-style-type: none"> 1. The cutting speed is too fast. 2. The blade TPI is too coarse. 3. The blade feed pressure is too light. 4. The workpiece has hard spots, welds, or scale is on the material. 5. The blade is twisted. 6. The blade is slipping on the wheels. 	<ol style="list-style-type: none"> 1. Refer to Changing Blade Speed on Page 23, and adjust as required. 2. Refer to Blade Selection on Page 24, and adjust as required. 3. Refer to Feed Rate on Page 26, and adjust as required. 4. Increase the feed pressure, and reduce the cutting speed. 5. Replace the blade. 6. Refer to Blade Tension on Page 34, and adjust as required.
Blade wears on one side.	<ol style="list-style-type: none"> 1. The blade guides are worn or mis-adjusted. 2. The blade guide slide bracket is loose. 3. The wheels are out of alignment. 	<ol style="list-style-type: none"> 1. Refer to Blade Guides on Page 24 and replace or adjust. 2. Tighten the blade guide bracket. 3. Refer to Blade Tracking on Page 34, and adjust as required.
Teeth are ripping from the blade.	<ol style="list-style-type: none"> 1. The feed pressure is too heavy and the blade speed is too slow; or the blade TPI is too coarse for the workpiece. 2. The workpiece is vibrating in the vise. 3. The blade gullets are loading up with chips. 	<ol style="list-style-type: none"> 1. Refer to Blade Selection on Page 24 and decrease the feed pressure. Refer to Feed Rate on Page 26, and adjust as required. 2. Re-clamp the workpiece in the vise, and use a jig if required. 3. Use a coarser-tooth blade.



Blade Change

Blades should be changed when they become dull, damaged, or when you are using materials that require a blade of a certain type or tooth count.

To change the blade on the bandsaw:

1. UNPLUG THE BANDSAW!
2. Raise the bow of the bandsaw to the highest position, close the feed ON/OFF valve, and remove the wheel access cover.
3. Remove the blade guards.
4. Loosen the tension handle in **Figure 43** and slip the blade off of the wheels.

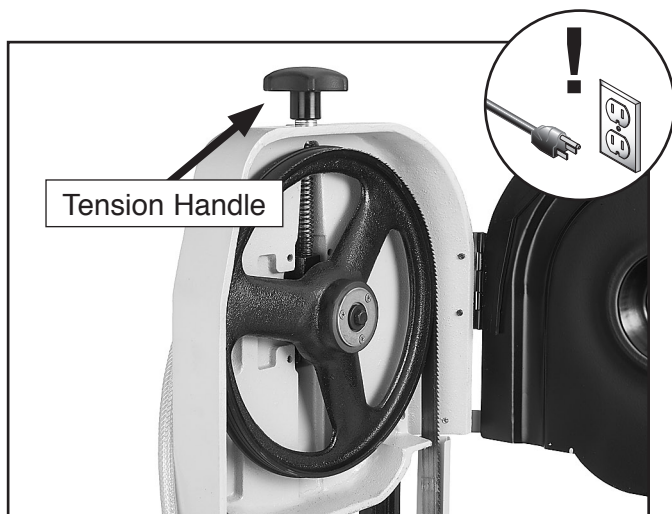


Figure 43. Tension handle and blade.

CAUTION

CUTTING HAZARD! Bandsaw blades are sharp and awkward to hold. Protect your hands with heavy gloves when handling blade.

5. Install the new blade through both blade guide bearings, as shown in **Figure 44**, and around the bottom wheel.

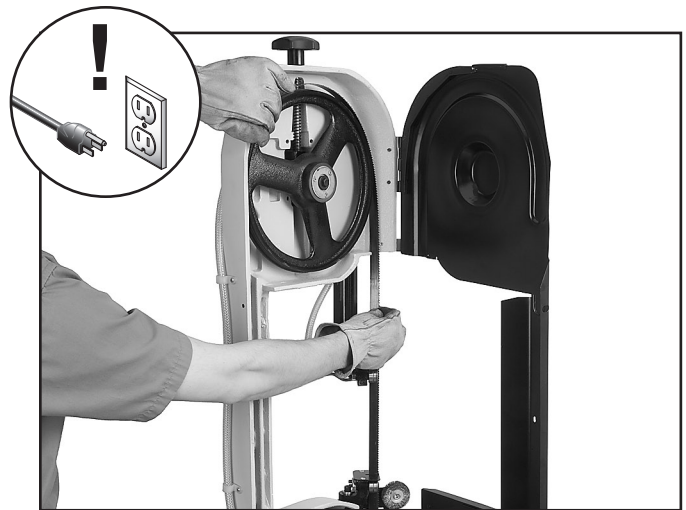


Figure 44. Installing blade.

6. Hold the blade around the bottom wheel with one hand and slip it around the top wheel with the other hand, keeping the blade between the blade guide bearings.

Note: It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth are facing toward the workpiece, as shown in **Figure 45**, after mounting on the bandsaw. Some blades will have a directional arrow as a guide.

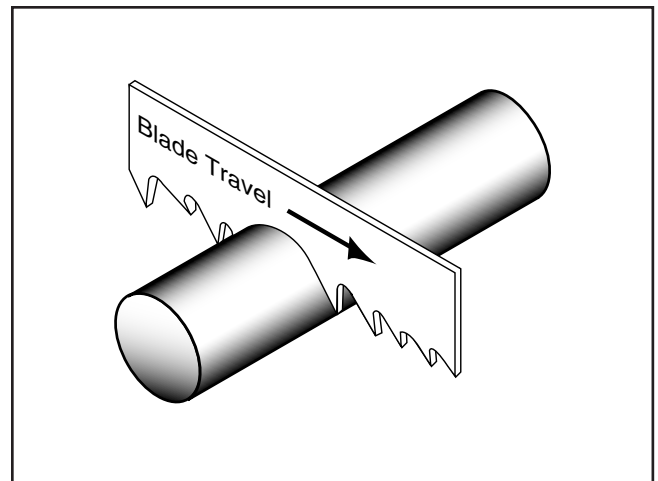


Figure 45. Blade cutting direction.

7. When the blade is around both wheels, adjust the position so the back of the blade is against the shoulder of the wheels.
8. Complete the blade change by following the steps in **Blade Tension & Tracking**.



Blade Tension & Tracking

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting. The Model G0561 features a blade tension indicator to assist you with blade tensioning.

Two major signs that you do not have proper blade tension are: 1) the blade stalls in the cut and slips on the wheels, and 2) the blade frequently breaks from being too tight.

NOTICE

Loosen blade tension at the end of each day to prolong blade life.

To tension the blade on the bandsaw:

1. Turn the blade tension handle clockwise to tension the blade.
2. Tension the blade until the blade tension guide indicator is in the green zone (**Figure 46**).
3. To fine tune blade tension, use a blade tensioning gauge, like the one found in **SECTION 5: ACCESSORIES** on **Page 28**. Please follow the instructions included with your gauge and the blade manufacturer's recommendations on blade tension.

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly.

To adjust the blade tracking on the bandsaw:

1. UNPLUG THE BANDSAW!
2. Position the bandsaw in the vertical position.
3. Open the wheel access cover.
4. Loosen, but do not remove the lower hex bolt in the blade wheel tilting mechanism (**Figure 46**).

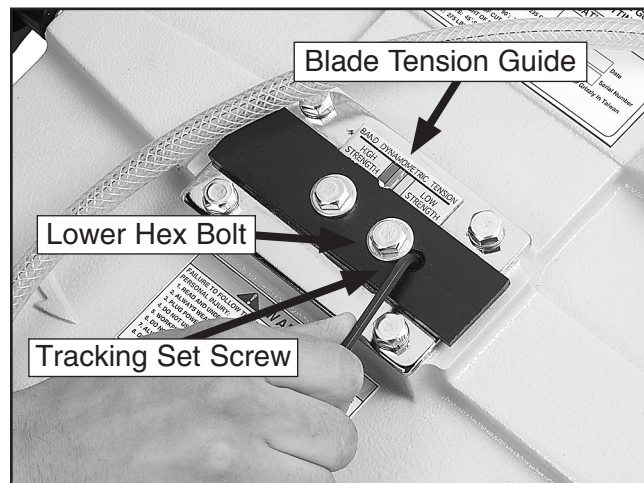


Figure 46. Blade tension guide.

5. Relax the blade tension.
6. Adjust the set screw with a 4mm hex wrench shown in **Figure 46**, then tighten the hex bolt loosened in **Step 4**.
 - Tightening the set screw will move the blade closer to the shoulder of the wheel.
 - Loosening the set screw will move the blade away from the shoulder.
7. Tension the blade.
8. Reconnect the power and turn **ON** the bandsaw.
 - If the blade tracks along the shoulder of the wheel (without rubbing), the blade is tracking properly and this adjustment is completed.
 - If the blade walks away from the shoulder of the wheel or hits the shoulder, repeat **Steps 4-7** until the blade tracks properly.
9. Turn **OFF** the bandsaw.
10. Replace the blade guard and wheel access cover.



Squaring the Blade

It is always a good idea during the life of your saw to check and adjust this setting. This adjustment will improve your cutting results and extend the life of your blade.

To square the blade to the bed of the table:

1. UNPLUG THE BANDSAW!
2. Lower the head of the bandsaw all the way until it contacts the horizontal stop.
3. Place a square on the table bed and against the edge of the blade (**Figure 47**), and check different points along the length of the table between the blade guides.
4. Loosen the cap screw shown in **Figure 47**, and rotate the blade guide until the blade is vertical to the bed, then tighten the cap screw.

Note: *Both blade guides can be adjusted to achieve the results you want.*

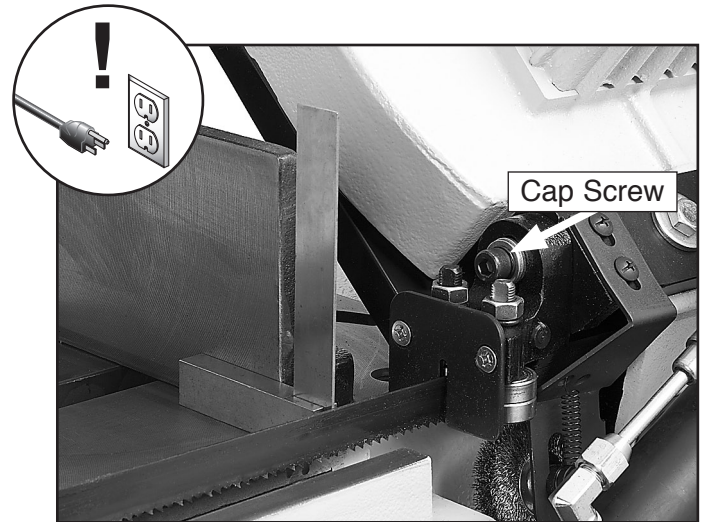


Figure 47. Squaring the blade.



Blade Guide Bearings

The blade guide bearings come adjusted from the factory and the need for adjustment should rarely occur. Uneven blade wear and crooked cuts may be the result of improper adjustment. Each bearing assembly has an eccentric bushing that allows the distance between the blade and bearings to be adjusted. The bearings are secured in place by a hex nut and a lock washer as shown in **Figure 48**.

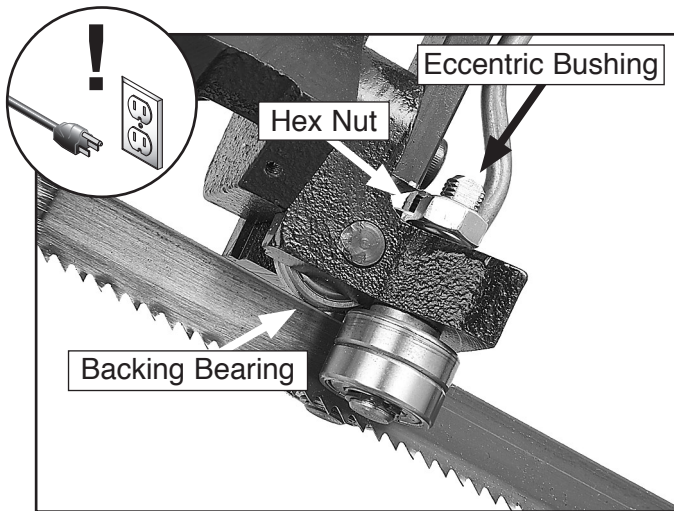


Figure 48. Blade guide adjustments.

To adjust the blade guide bearings:

1. UNPLUG THE BANDSAW!
2. Raise the bandsaw to approximately 45° and close the feed rate ON/OFF valve.
3. Loosen the hex nut that secures the eccentric bushing.
4. Adjust the eccentric bushing position to achieve the desired clearance. The bearing and blade should make light contact or have a clearance of 0.001"-0.002".
5. Tighten the nut to lock the eccentric bushing and bearing in position.
6. Adjust the other eccentric blade guide bearing in the same manner. The backing bearing is not adjustable and will make light contact with the blade.
7. Adjust the carbide blade guides so they make the same contact with the blade as the bearings.



Electrical Components

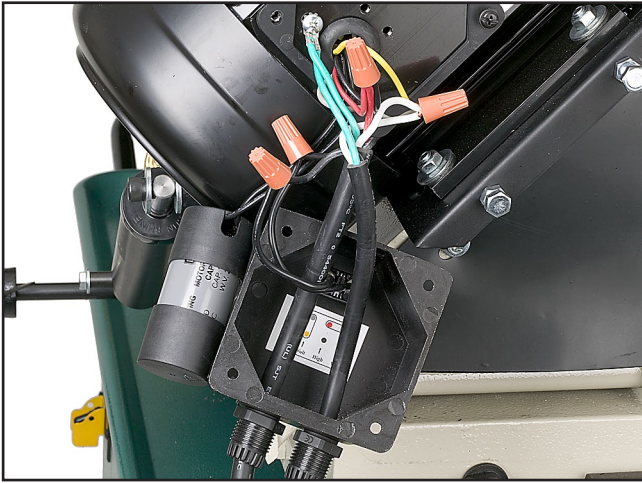


Figure 49. Circuit breaker and capacitor.

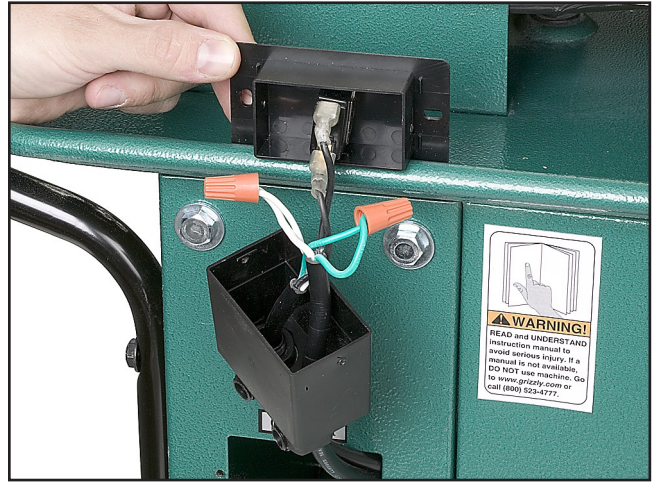


Figure 51. Coolant pump ON/OFF Switch.

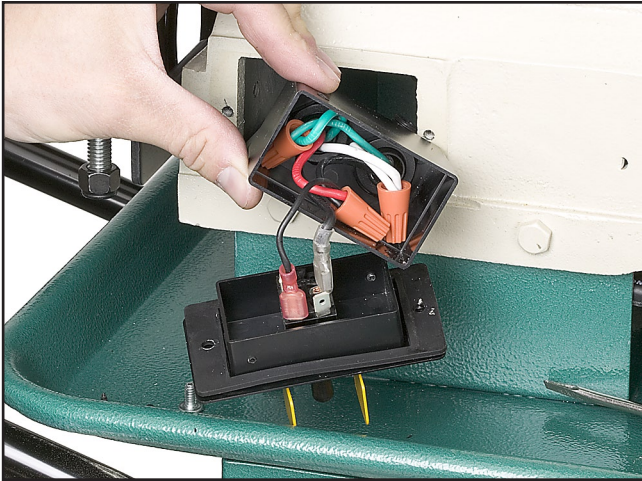


Figure 50. Power switch.

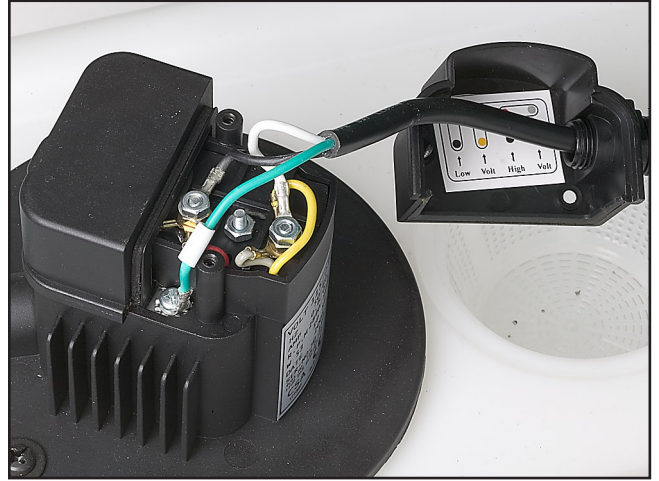
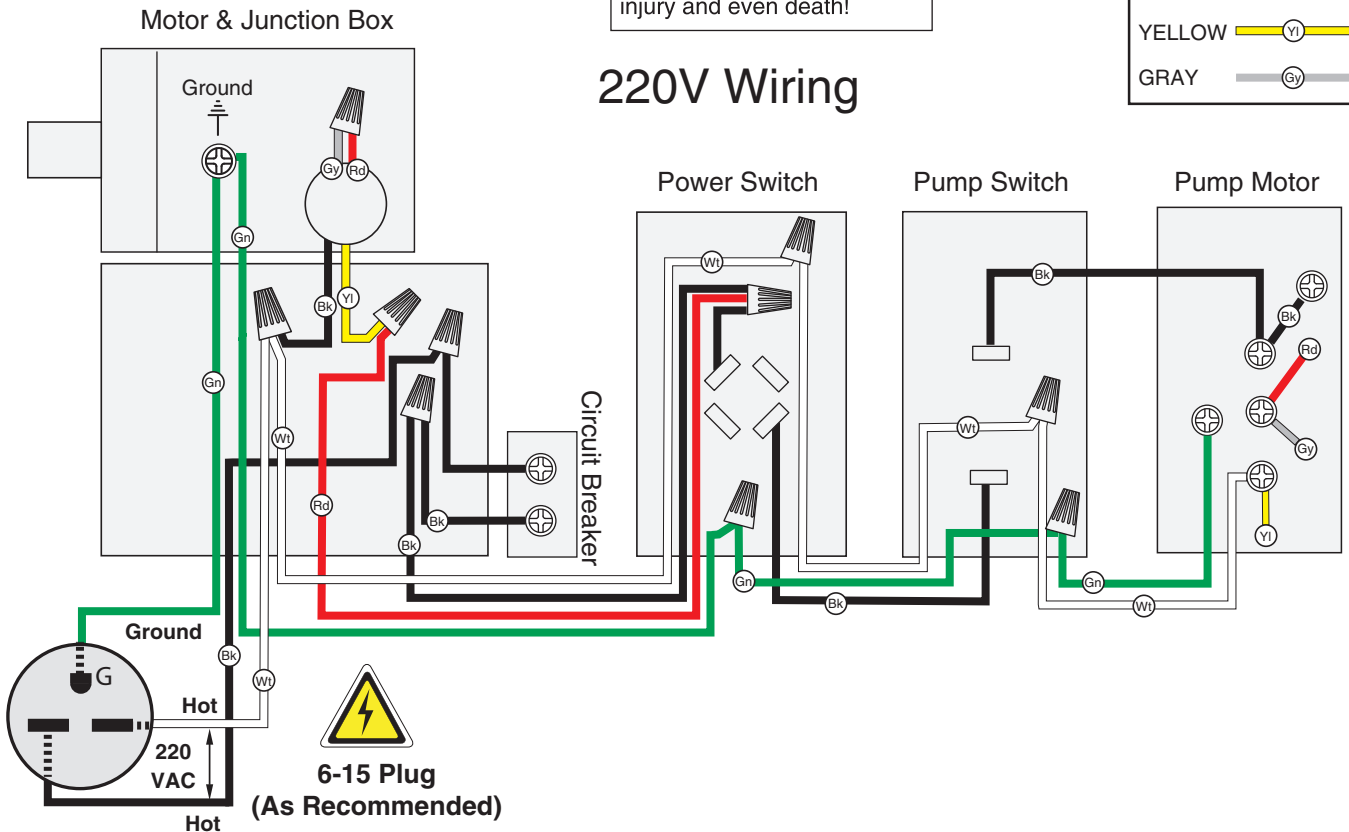
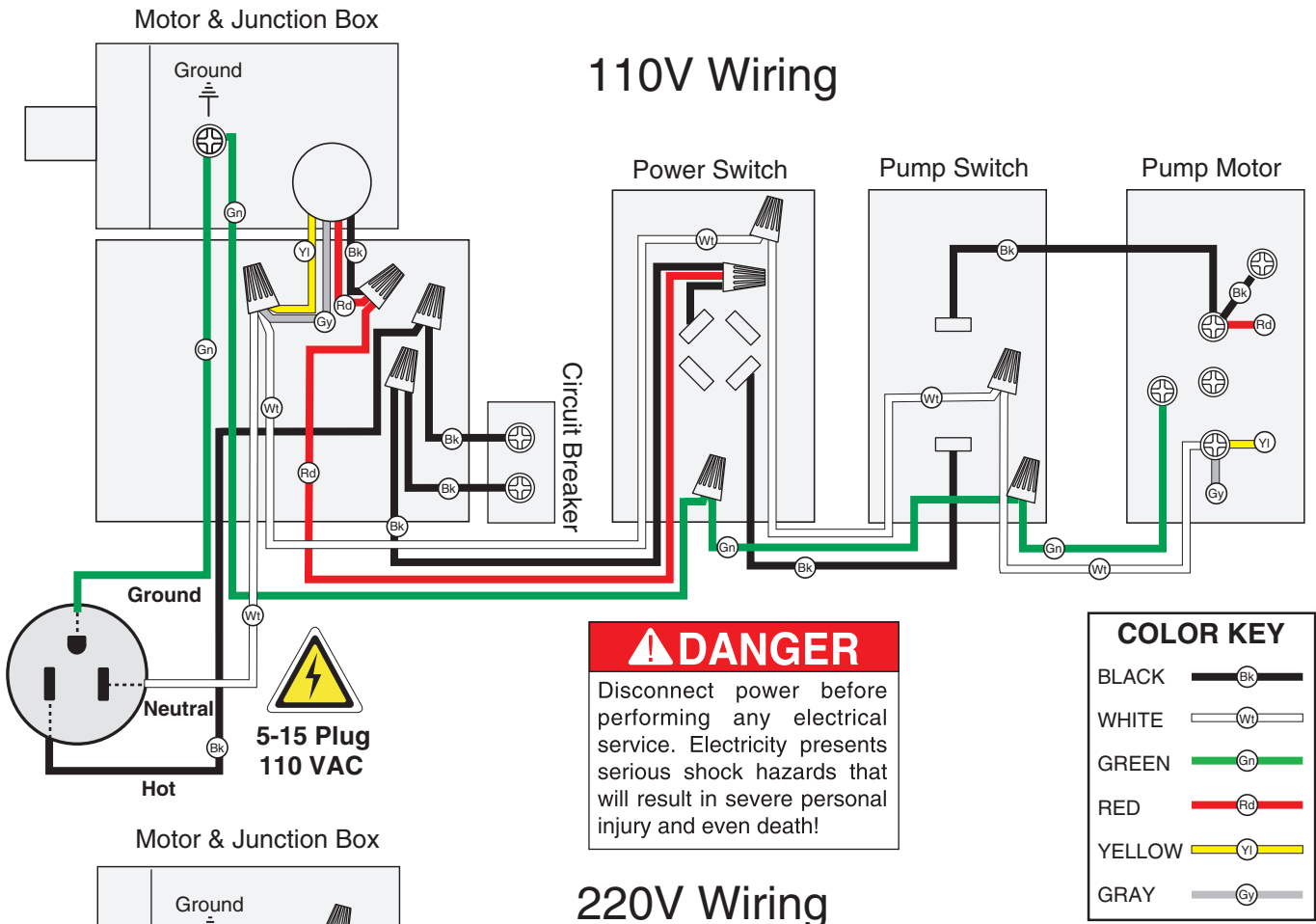


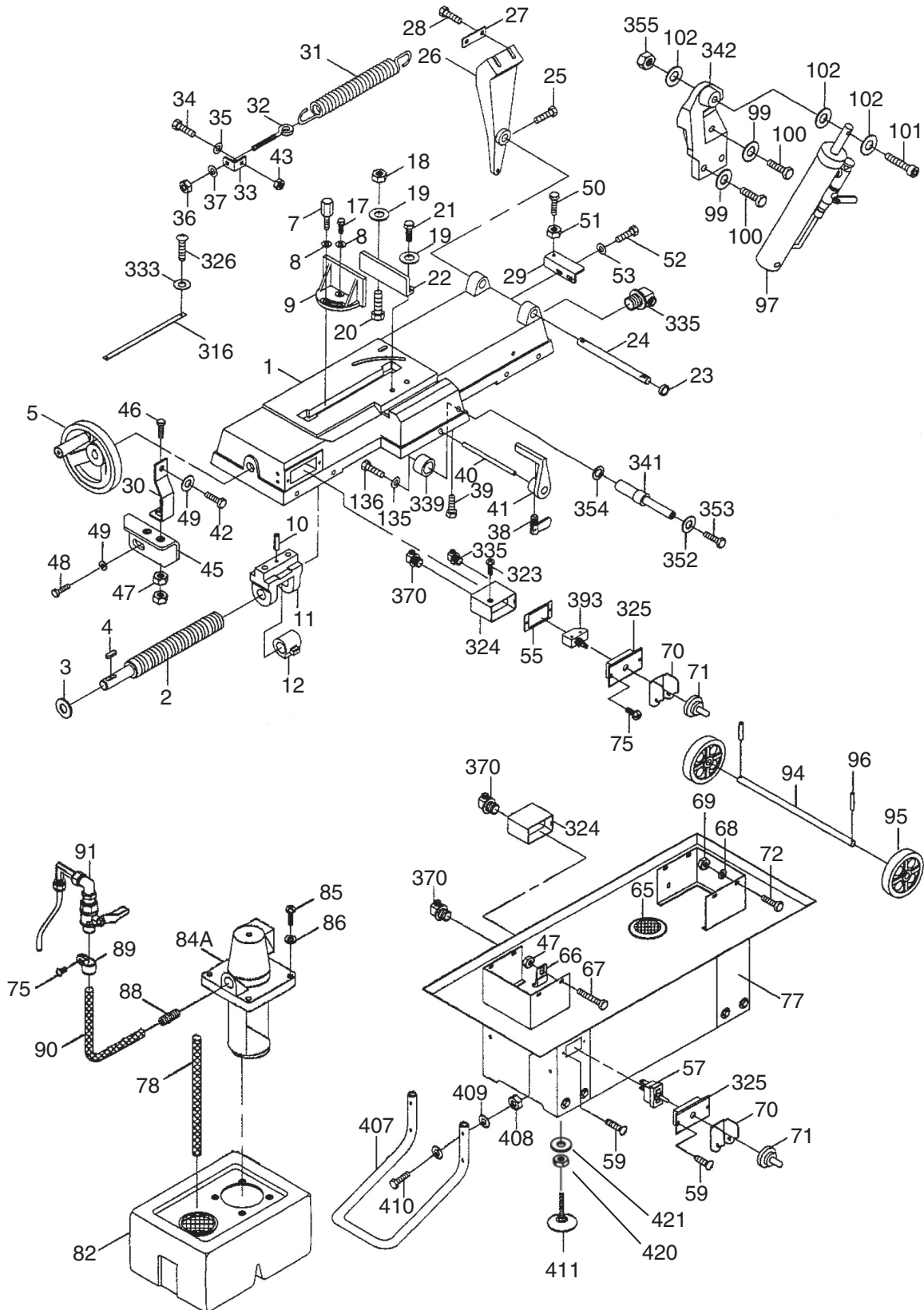
Figure 52. Pump motor 110V connection.



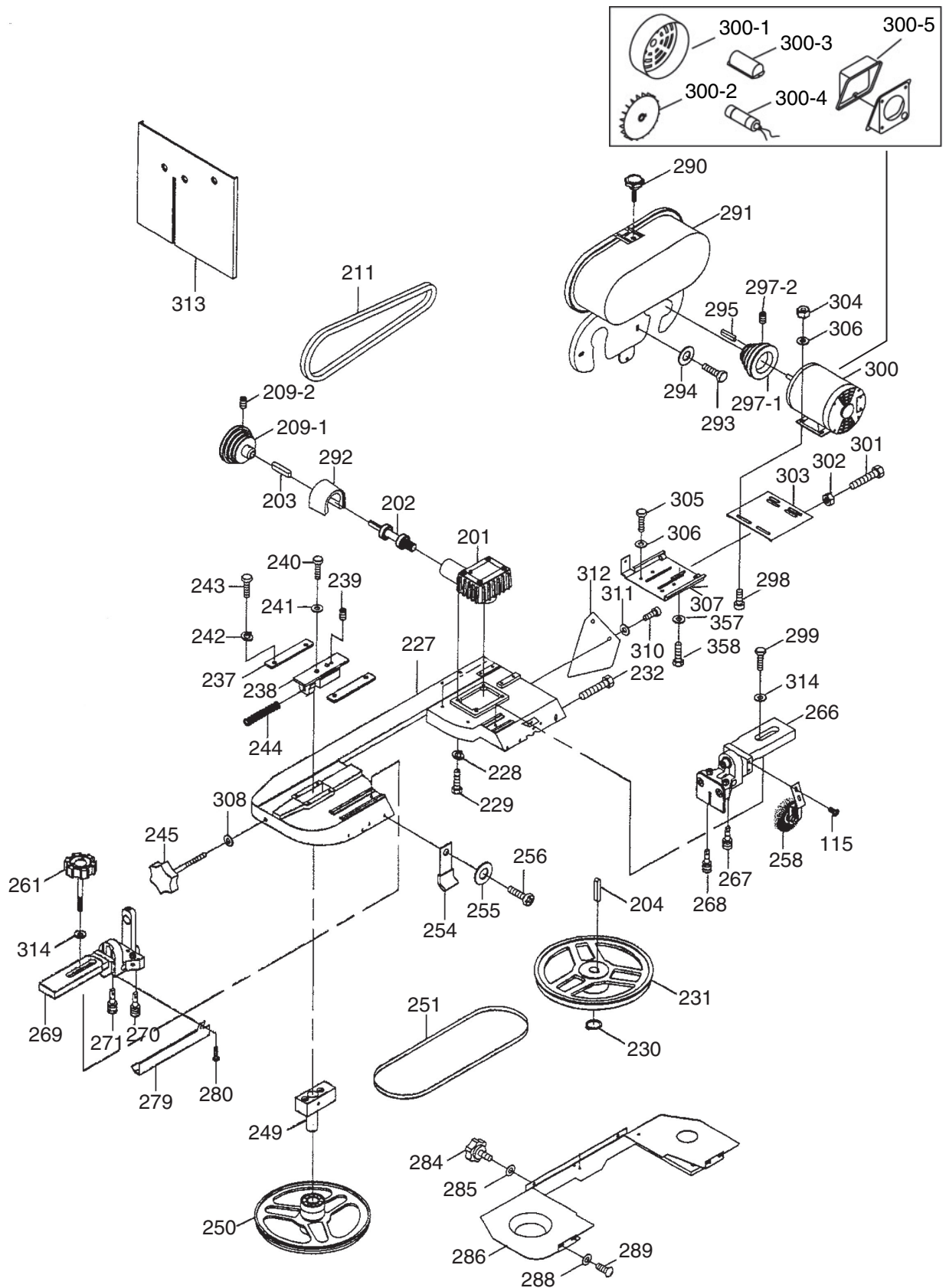
G0561 110V & 220V Wiring Diagram



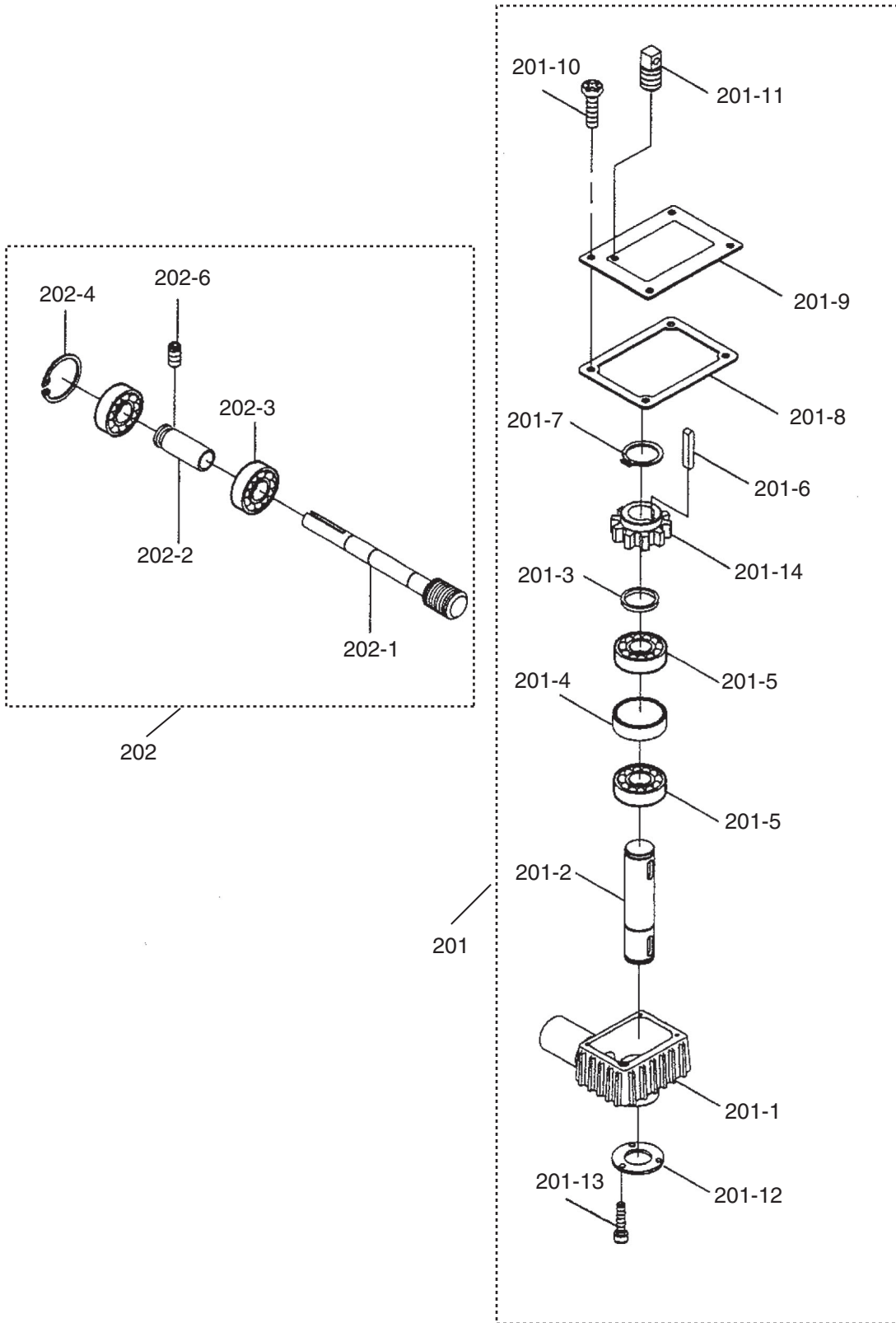
G0561 Cabinet/Base



G0561 Bow/Motor



G0561 Gear Box



Parts List

REF	PART #	DESCRIPTION
1	P0561001	BASE
2	P0561002	ACME SCREW 22 x 5 x 480
3	PW01	FLAT WASHER 1/2
4	PK20M	KEY 5 X 5 X 15
5	P0561005	WHEEL
7	P0561007	FIXED BOLT 3/8 - 16
8	PW02	FLAT WASHER 3/8
9	P0561009	WISE JAW BRACKET (FRONT)
10	PRP77M	ROLL PIN 5 X 34
11	P0561011	BRACKET
12	P0561012	ACME NUT ASSY 22 x 5
17	PB16	HEX BOLT 3/8-16 X 1-1/2
18	PN06	HEX NUT 1/2-12
19	PW01	FLAT WASHER 1/2
20	P0561020	CARRIAGE BOLT 1/2-12 x 2
21	PB72	HEX BOLT 1/2-13 X 2
22	P0561022	WISE JAW BRACKET (REAR)
23	P0561023	BUSHING
24	P0561024	SUPPORT ROD
25	PB07	HEX BOLT 5/16-18 X 3/4
26	P0561026	PIVOT BRACKET
27	P0561027	SQUARE WASHER 75 x 25.4
28	PB16	HEX BOLT 3/8-16 X 1-1/2
29	P0561029	SUPPORT PLATE
30	P0561030	SHIPPING BRACKET
31	P0561031	EXTENSION SPRING 32 x 282
32	P0561032	SPRING ADJUSTING ROD
33	P0561033	SPRING HANDLE BRACKET
34	PB07	HEX BOLT 5/16-18 X 3/4
35	PW07	FLAT WASHER 5/16
36	PN08	HEX NUT 3/8-16
37	PW02	FLAT WASHER 3/8
38	P0561038	THUMB SCREW 5/16-18
39	PB07	HEX BOLT 5/16-18 X 3/4
40	P0561040	WORK STOP ROD
41	P0561041	WORK STOP
42	PB11	HEX BOLT 5/16-18 X 1-1/2
43	PN02	HEX NUT 5/16-18
45	P0561045	SUPPORT PLATE
46	PB25	HEX BOLT 3/8-16 X 1-3/4

REF	PART #	DESCRIPTION
47	PN08	HEX NUT 3/8-16
48	PB07	HEX BOLT 5/16-18 X 3/4
49	PW07	FLAT WASHER 5/16
50	PB25	HEX BOLT 3/8-16 X 1-3/4
51	PN08	HEX NUT 3/8-16
52	PB07	HEX BOLT 5/16-18 X 3/4
53	PW13	FLAT WASHER 3/4
55	P0561055	RUBBER PLATE
57	P0561057	TOGGLE SWITCH ASSEMBLY
59	PS06	PHLP HD SCR 10-24 X 3/8
65	P0561065	CHIP SCREEN
66	P0561066	SWITCH CUT OFF TIP
67	PB24	HEX BOLT 3/8-16 X 1-1/4
68	PW07	FLAT WASHER 5/16
69	PN02	HEX NUT 5/16-18
70	P0561070	SWITCH COVER
71	P0561071	TOGGLE SWITCH COVER
72	PB03	HEX BOLT 5/16-18 X 1
75	PS06	PHLP HD SCR 10-24 X 3/8
77	P0561077	STAND COMPLETE ASSEMBLY
78	P0561078	HOSE 5/8 X 200MM
82	P0561082	COOLANT TANK
84A	P0561084A	PUMP N/S
85	PS12	PHLP HD SCR 1/4-20 X 5/8
86	PW06	FLAT WASHER 1/4
88	P0561088	COUPLER 3/8 PT X 5/16
89	P0561089	HOSE CLIP 5/8
90	P0561090	HOSE OD12 X ID8 X 2000
91	P0561091	FITTING
94	P0561094	WHEEL ROD
95	P0561095	WHEEL
96	P0561096	COTTER PIN 3 X 25
97	P0561097	CYLINDER COMPLETE
99	PW07	FLAT WASHER 5/16
100	PB03	HEX BOLT 5/16-18 X 1
101	PSB29	CAP SCREW 3/8-16 X 2-1/4
102	PW02	FLAT WASHER 3/8
115	PS06	PHLP HD SCR 10-24 X 3/8
135	PW07	FLAT WASHER 5/16
136	PB07	HEX BOLT 5/16-18 X 3/4



Parts List

REF	PART #	DESCRIPTION
201	P0561201	GEAR BOX ASSEMBLY
201-1	P0561201-1	GEAR BOX
201-2	P0561201-2	TRANSMISSION WHEEL SHAFT
201-3	P0561201-3	BUSHING
201-4	P0561201-4	BUSHING
201-5	P6205	BALL BEARING 6205ZZ
201-6	P0561201-6	WORM GEAR KEY
201-7	PR11M	EXT RETAINING RING 25MM
201-8	P0561201-8	GEAR BOX GASKET
201-9	P0561201-9	GEAR BOX COVER
201-10	PS04	PHLP HD SCR 1/4-20 X 1/2
201-11	P0561201-11	VENT PLUG
201-12	P0561201-12	BEARING COVER
201-13	PS06	PHLP HD SCR 10-24 X 3/8
201-14	P0561201-14	WORM GEAR
202	P0561202	WORM GEAR SHAFT ASSEMBLY
202-1	P0561202-1	WORM SHAFT
202-2	P0561202-2	BEARING BUSHING
202-3	P6003	BALL BEARING 6003ZZ
202-4	P0561202-4	INT RETAINING RING 17MM
202-6	PSS08	SET SCREW 5/16-18 X 1/2
203	PK12M	KEY 5 X 5 X 30
204	PK07M	KEY 6 X 6 X 20
209-1	P0561209-1	SPINDLE PULLEY
209-2	PSS03	SET SCREW 1/4-20 X 3/8
211	PVM27	V-BELT M-27 3L270
227	P0561227	BODY FRAME
228	PLW04	LOCK WASHER 3/8
229	PB24	HEX BOLT 3/8-16 X 1-1/4
230	PR11M	EXT RETAINING RING 25MM
231	P0561231	DRIVE WHEEL ASSEMBLY
232	PB07	HEX BOLT 5/16-18 X 3/4
237	P0561237	SLIDING PLATE
238	P0561238	BLADE TENSION SLIDING BLOCK
239	PSS18	SET SCREW 5/16-18 X 3/4
240	PB11	HEX BOLT 5/16-18 X 1-1/2
241	PW07	FLAT WASHER 5/16
242	PLW01	LOCK WASHER 5/16
243	PB07	HEX BOLT 5/16-18 X 3/4
244	P0561244	COMPRESSION SPRING 115 x 4

REF	PART #	DESCRIPTION
245	P0561245	BLADE ADJUSTABLE KNOB
249	P0561249	SHAFT ASSEMBLY
250	P0561250	IDLER WHEEL ASSEMBLY
251	P0561251	BLADE 0.032 X 3/4 X 93 X 6-10T
254	P0561254	SWITCH CUT OFF TIP
255	PW06	FLAT WASHER 1/4
256	PS04	PHLP HD SCR 1/4-20 X 1/2
258	P0561258	BRUSH ASSEMBLY
261	P0561261	BLADE ADJUSTABLE KNOB
266	P0561266	ADJ BRACKET ASSY (REAR)
267	P0561267	GUIDE PIVOT ASSEMBLY
268	P0561268	BEARING SHAFT ASSEMBLY
269	P0561269	ADJ BRACKET (FRONT)
270	P0561270	GUIDE PIVOT ASSEMBLY
271	P0561271	BEARING SHAFT ASSEMBLY
279	P0561279	BLADE COVER (FRONT)
280	PS41	PHLP HD SCR 6-32 X 1/4
284	P0561284	COVER KNOB
285	PW06	FLAT WASHER 1/4
286	P0561286	BLADE BACK COVER
288	PW06	FLAT WASHER 1/4
289	PS04	PHLP HD SCR 1/4-20 X 1/2
290	P0561290	PLUM HANDLE
291	P0561291	MOTOR PULLEY COVER
292	P0561292	COVER
293	PS04	PHLP HD SCR 1/4-20 X 1/2
294	PW06	FLAT WASHER 1/4
295	PK12M	KEY 5 X 5 X 30
297-1	P0561297-1	MOTOR PULLEY
297-2	PSS03	SET SCREW 1/4-20 X 3/8
298	PCB05	CARRIAGE BOLT 5/16-18 X 3/4
299	PB24	HEX BOLT 3/8-16 X 1-1/4
300	P0561300	MOTOR
300-1	P0561300-1	MOTOR FAN COVER
300-2	P0561300-2	MOTOR FAN
300-3	P0561300-3	CAPACITOR COVER
300-4	P0561300-4	CAPACITOR 150MFD 250VAC
300-5	P0561300-5	JUNCTION BOX
301	PB06	HEX BOLT 5/16-18 X 2
302	PN02	HEX NUT 5/16-18



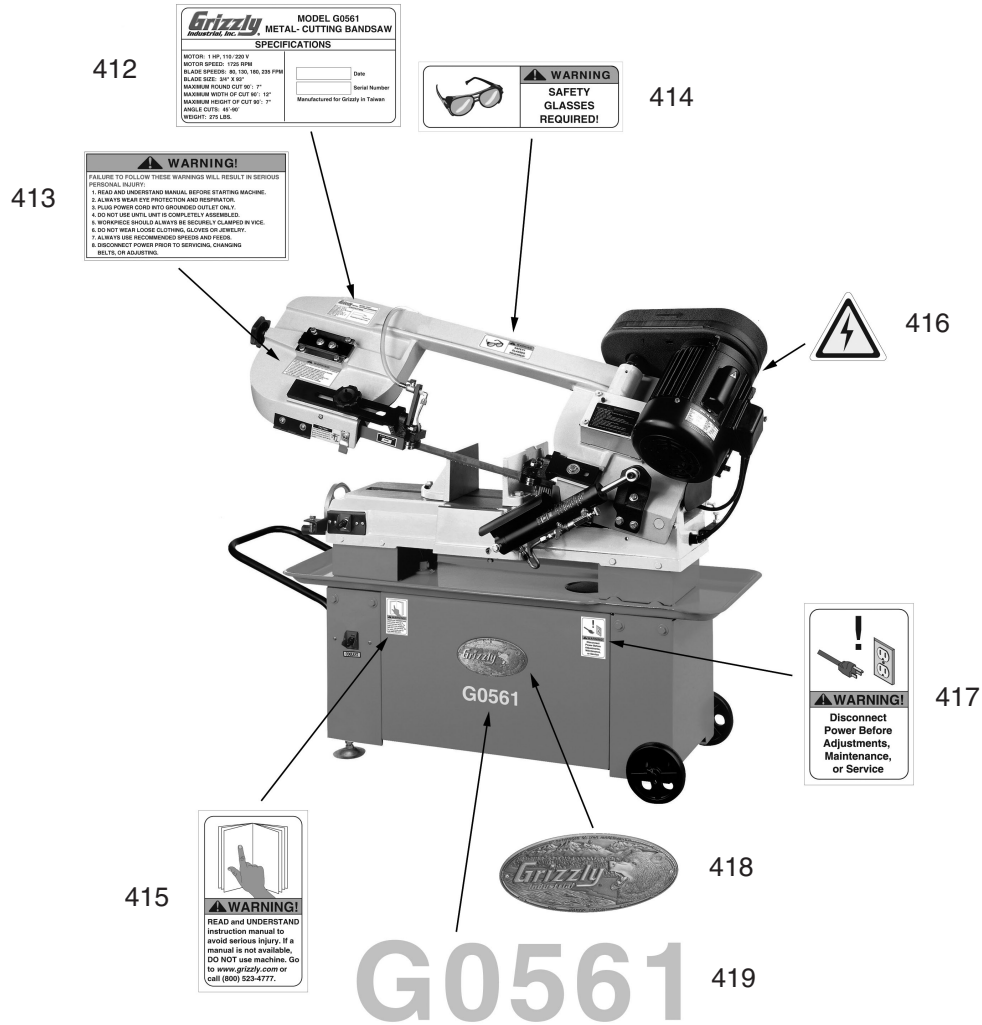
Parts List

REF	PART #	DESCRIPTION
303	P0561303	MOTOR MOUNT PLATE
304	PN02	HEX NUT 5/16-18
305	PB07	HEX BOLT 5/16-18 X 3/4
306	PW07	FLAT WASHER 5/16
307	P0561307	MOTOR MOUNT BRACKET
308	PW02	FLAT WASHER 3/8
310	PS04	PHLP HD SCR 1/4-20 X 1/2
311	PW06	FLAT WASHER 1/4
312	P0561312	SUPPORT PLATE
313	P0561313	VERTICAL SAW TABLE
314	PW02	FLAT WASHER 3/8
316	P0561316	SCALE
324	P0561324	ELECTRICAL BOX
325	P0561325	COVER
326	PS06	PHLP HD SCR 10-24 X 3/8
333	PW03	FLAT WASHER #10
335	P0561335	STRAIN RELIEF 5/8
339	P0561339	BUSHING

REF	PART #	DESCRIPTION
341	P0561341	CYLINDER LOWER SUPPORT
342	P0561342	CYLINDER UPPER SUPPORT
352	PW07	FLAT WASHER 5/16
353	PB09	HEX BOLT 5/16-18 X 1/2
354	P0561354	SPECIAL WASHER 8 x 16 x 2
355	PN08	HEX NUT 3/8-16
357	PW07	FLAT WASHER 5/16
358	PB07	HEX BOLT 5/16-18 X 3/4
370	P0561370	STRAIN RELIEF 1/2
393	P0561393	TOGGLE SWITCH
407	P0561407	HANDLE
408	PN08	HEX NUT 3/8-16
409	PW02	FLAT WASHER 3/8
410	PB24	HEX BOLT 3/8-16 X 1-1/4
411	P0561411	LEVELING FOOT
420	PN08	HEX NUT 3/8-16
421	PW02	FLAT WASHER 3/8



Machine Labels & Parts List



REF	PART #	DESCRIPTION
412	P0561412	MACHINE ID LABEL
413	P0561413	MACHINE WARNING LABEL
414	P0561414	SAFETY GLASSES LABEL
415	PLABEL-12	READ MANUAL
416	PLABEL-14	ELECTRICITY LABEL
417	PLABEL-18	UNPLUG BANDSAW LABEL
418	G8588	GRIZZLY LOGO PLATE
419	P0561419	MODEL NUMBER LABEL

WARNING

The safety labels on this machine warn and indicate how to protect the operator or bystander from machine hazards. The machine owner **MUST** maintain the original label location and readability. If a label is removed or becomes unreadable, **REPLACE** the label before using the machine. For new labels, contact Grizzly Industrial Inc. at (570) 546-9663 or techsupport@grizzly.com.



WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.





WARRANTY CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____ Invoice # _____
 Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

1. How did you learn about us?

Advertisement Friend Catalog
 Card Deck Website Other:

2. Which of the following magazines do you subscribe to?

<input type="checkbox"/> Cabinet Maker	<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Today's Homeowner
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wood
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Handy	<input type="checkbox"/> Practical Homeowner	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Live Steam	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Modeltec	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Shotgun News	

3. What is your annual household income?

\$20,000-\$29,000 \$30,000-\$39,000 \$40,000-\$49,000
 \$50,000-\$59,000 \$60,000-\$69,000 \$70,000+

4. What is your age group?

20-29 30-39 40-49
 50-59 60-69 70+

5. How long have you been a woodworker/metalworker?

0-2 Years 2-8 Years 8-20 Years 20+ Years

6. How many of your machines or tools are Grizzly?

0-2 3-5 6-9 10+

7. Do you think your machine represents a good value?

Yes No

8. Would you recommend Grizzly Industrial to a friend?

Yes No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

Note: *We never use names more than 3 times.* Yes No

10. Comments: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE



Place
Stamp
Here



GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069



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City _____ State _____ Zip _____

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